

# Ferromaxx<sup>®</sup> 15



## For faster, cleaner welding of steel



Purpose-designed for MAG welding of carbon, carbon manganese and low-alloy steels, the Ferromaxx gases give superb weld quality and excellent penetration, together with minimal spatter and low fume levels.

### Features/benefits

Ferromaxx 15 is a ternary mixture (of argon, CO<sub>2</sub> and oxygen) used to weld carbon steels of all thicknesses. The action of oxygen on the transfer of metal allows for greater arc stability.

- Improves weld quality and reduces spatter; excellent penetration characteristics
- Excellent weld control
- Protects the work environment; minimal ozone generation



## Approved Welding Procedure Ferromaxx 15

Manufacturer:	Air Products
Welding Process:	GMAW (MAG 135)
Root Welding Process:	GMAW (MAG 135)
Joint Type:	Groove (Butt)

### Joint Design

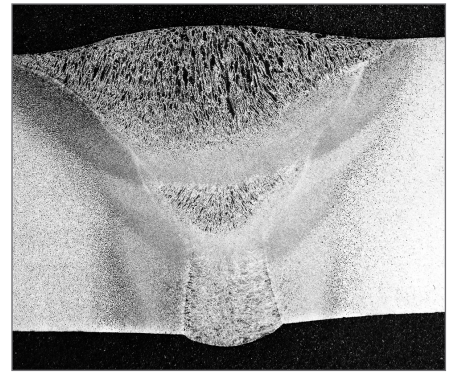
Preparation of Parts	Machined Preparations Sandblasting and Solvent Cleaning
Parent Material and Specification	BS 970: Part 3 Grade 080A15
Composition	C-0.13%/0.18% Si-0.10%/0.40% Mn-0.60%/1.0% P-0.050% max. S-0.050% max.
Material Thickness	1/2"
Outside Diameter	n/a
Welding Position	1G (Flat)

### Welding Details

Run	Process	Diameter of Filler Metal (inch)	Current (A)	Voltage (V)	Type of Current & Polarity	Wire Feed Speed (IPM)	Travel Speed (IPM)	Heat Input (KJ/inch)
1	GMAW	.040	194	26	DC+	350	11	1.1 KJ/inch
2	GMAW	.045	256	27	DC+	338	12.5	1.3 KJ/inch
3	GMAW	.045	270	28.5	DC+	346	15.75	1.1 KJ/inch
4								
5								
6								

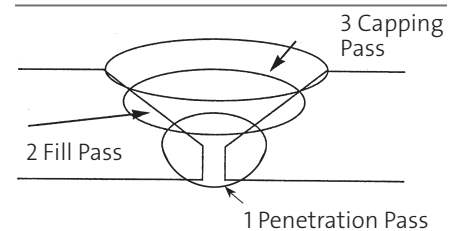
Filler Metal and Specification	AWS-A5.18 ER 70S-6 (SG3Si)
Filler Metal Composition	C-0.12% max. - Si-0.70%/1.2% Mn-0.9%/1.6%-P-0.040% max. S-0.040% - Cu - 0.040% max.
Shielding Gas	Ferromaxx 15
Classification of Shielding Gas	EN 439-M24
Gas Flow Rate	
Shield Gas	35-45 CFH
Purge Gas	n/a
TIG Electrode Type	n/a
Underside Protection	n/a
Preheat Temperature	Ambient
Interpass Temperature	n/a
Heat Treatment	n/a
Stand Off Distance	5/8"
Torch Angle	15° in the Direction of Welding
Nozzle Bore Diameter	3/4"

\*n/a : not applicable



Macrography

### Welding Sequence



For more information,  
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