Ferromaxx® 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, CO₂ 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

<table>
<thead>
<tr>
<th>Run</th>
<th>Process</th>
<th>Diameter of Filler Metal (inch)</th>
<th>Current (A)</th>
<th>Voltage (V)</th>
<th>Type of Current &amp; Polarity</th>
<th>Wire Feed Speed (IPM)</th>
<th>Travel Speed (IPM)</th>
<th>Heat Input (KJ/inch)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>GMAW</td>
<td>.040</td>
<td>194</td>
<td>26</td>
<td>DC+</td>
<td>350</td>
<td>11</td>
<td>1.1 KJ/inch</td>
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<tr>
<td>2</td>
<td>GMAW</td>
<td>.045</td>
<td>256</td>
<td>27</td>
<td>DC+</td>
<td>338</td>
<td>12.5</td>
<td>1.3 KJ/inch</td>
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<tr>
<td>3</td>
<td>GMAW</td>
<td>.045</td>
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<td>28.5</td>
<td>DC+</td>
<td>346</td>
<td>15.75</td>
<td>1.1 KJ/inch</td>
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</tbody>
</table>

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

For more information, please contact us at:

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