Ferromaxx® 7
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 7 is a ternary mixture (of argon, CO₂ and oxygen) specially formulated to weld carbon steels, galvanized and electrogalvanized sheet steel.

- Improves weld quality and reduces rejects; excellent weld control, particularly at low voltages on thin and medium thickness materials (up to 1/2" thick) and for positional welding
- Low spatter levels cut post-weld cleaning times; excellent pulsed arc characteristics
**Approved Welding Procedure Ferromaxx 7**

**Manufacturer:** Air Products

**Main Welding Process:** GMAW (MAG 135)

**Root Welding Process:** n/a

**Joint Type:** Fillet

### Joint Design

**Preparation of Parts:** Sandblasting and solvent cleaning

**Parent Material and Specifications:** 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:** 1/4"

**Outside Diameter:** n/a

**Welding Position:** 2F

### 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 (MAG 135)</td>
<td>.045</td>
<td>208</td>
<td>23.5</td>
<td>DC+</td>
<td>390</td>
<td>13</td>
<td>0.8</td>
</tr>
</tbody>
</table>

**Filler Metal and Specification:** AWS-A5.18 ER 70S-6 (SG3Si)

**Filler Metal Composition:** Carbon Steel
- C – 0.12% max. – Si – 0.70%/1.2%
- Mn – 0.9%/1.6% – P – 0.040% max.
- S – 0.040% max. – Cu – 0.040% max.

**Shielding Gas:** Ferromaxx 7

**Classification of Shielding Gas:** EN 439-M 24

**Gas Flow Rate:**
- Shield Gas: 35-45 CFH
- Purge Gas: n/a

**TIG Electrode Type:** 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

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For more information, please contact us at:

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