



MASTERWELD

MASTERWELD 15CDV6 Material No 1.7734

■ Description & Applications :

Copper coated welding filler rod for steels such as 15CrMoV6, 25CrMo4, 35CrMo4, 20CrMo12. Product of high purity for welding without micro porosity.

■ Classification :

EN10204 Type 3.1: 15CDV6 Material No 1.7734

■ Typical All Weld Metal Chemical Analysis % :

C	Mn	Fe	P	S	Si	Cr	V	Mo
0.14	1.0	Rem	<0.02	<0.02	0.15	1.4	0.25	0.9

■ All weld metal mechanical properties :

As Welded

Tensile Strength Rm (MPa)	1080-1280 Depending on heat treatment
Yield Strength Re (MPa)	930 Depending on heat treatment
A5(%)	10
Hardness(as welded)	42 HRC

■ Shielding Gas :

Pure Argon

■ Sizes available :

MIG	0.8mm	1.0mm	1.2mm	
TIG	0.8mm	1.2mm	1.6mm	2.0mm