

# Ferromaxx<sup>®</sup> 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, CO<sub>2</sub> 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

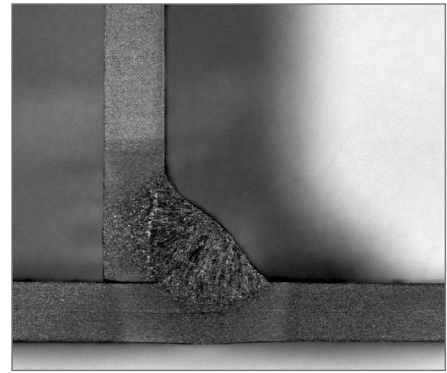
### Joint Design

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

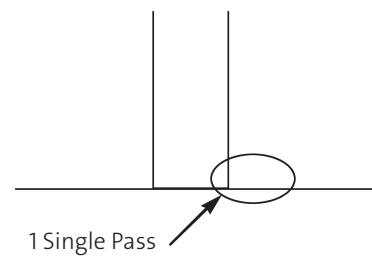
Run	Process	Diameter of Filler Metal (inch)	Current (A)	Voltage (V)	Type of Current & Polarity	Wire Feed Speed (IPM)	Travel Speed (IPM)	Heat Input (KJ/inch)
1	GMAW (MAG 135)	.045	208	23.5	DC+	390	13	0.8
2								
3								
4								
5								
6								
Filler Metal and Specification					AWS-A5.18 ER 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			
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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