

FLUXOFIL M8

Cored Wires C-Mn and low-alloy steels

Fluxofil M8 is a seamless copper coated metal cored wire with outstanding welding characteristics in the short-arc and spray-arc ranges depositing slag free weld metal. Almost spatter-free when welding in the spray-arc range. Good restraining, even with a cold wire tip, thus being suitable for robotic applications. Characteristic features: high deposition rate and welding speed, good side wall fusion, finely rippled welds, without undercut into the base metal, even on contaminated or corroded metal surfaces. Little formation of silicates on the weld surface, so multi-pass welds can be made without inter-run cleaning. Due to an easily controllable weld pool in the short-arc range, Fluxofil M 8 is well-suited for root- and positional welding and gap bridging.

Classification

AWS	A5.18: E70C-3M H4 / E70C-3C H4
EN	758: T 46 2 M M 1 H5 / T 46 2 M C 1 H5

Approvals

Grades

BV
DB
DNV
GL
LRS
TÜV

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.30	0.60	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
As Welded	≥ 460	550-660	≥ 24	≥ 50	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

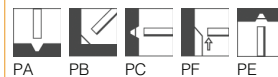
S(P)235-S(P)460

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg. 16

Diameters	1,0	1,2	1,6		
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