

FLUXOFIL M10

Cored Wires C-Mn and low-alloy steels

Fluxofil M10 is a seamless copper coated metal cored wire with outstanding welding properties in the short-arc and spray-arc ranges depositing slag free weld metal. Almost spatter-free when welding in the spray-arc range. Good restriking, even with a cold wire tip, thus being suitable for robotic applications. Characteristic features: good side wall fusion, smooth and finely rippled welds without undercut into the base metal. Little formation of silicates on top of weld, so that multi-pass welds can be made without inter-run cleaning. Due to an easily controllable weld pool in the short-arc range, Fluxofil M 10 is well-suited for root- and positional welding.

Classification	
AWS	A5.18: E70C-6M H4
EN	758: T 46 4 M M 1 H5

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
TÜV	
UDT	

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
0.06	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) - 40 °C	Hardness
PWHT 580 °C x 2 h/furnace	≥ 460	550-660	≥ 24	≥ 47	-
As Welded	≥ 460	550-660	≥ 24	≥ 47	-

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

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

Materials

S(P)235-S(P)420, GP240-GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+				
				
PA	PB	PC	PF	PE

Packaging data: K300 kg, 16

Diameters	1,0	1,2	1,6			
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