

FLUXOFIL M10S

Cored Wires C-Mn and low-alloy steels

Fluxofil M10S is a seamless copper coated metal cored wire producing no slag, for welding with both the single and multi-run techniques. Excellent weldability, high deposition rate, very good impact toughness at low temperatures, down to -60°C, both as welded and following post-weld heat treatment. Suitable for applications where very high toughness properties are required.

Classification	
AWS	5.18: E70C-6M H4
EN	758: T 42 6 MM 1 H5

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.30	0.36	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
PWHT 620 °C x 1h	≥ 410	500-550	≥ 27	≥ 100	-
As Welded	≥ 420	510-560	≥ 26	≥ 70	-

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+



Packaging data: K300 kg, 16

Diameters	1,2					
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