

Cored Wires C-Mn and low-alloy steels

Fluxofil 11 is a seamless copper coated rutile flux cored wire with a slow-freezing slag and outstanding welding properties in all positions, except in the vertical down and overhead positions. Negligible spatter loss, easy slag removal, smooth, finely rippled weld beads without undercutting into the base metal.

| Classification | |
|----------------|----------------------|
| AWS | A5.20: E70T-2 H4 |
| EN | 758: T 42 A R C 3 H5 |

| Approvals | Grades |
|-----------|--------|
| DB | |
| DNV | |
| 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 |
|------|------|------|---|---|----|----|----|----|---|---|----|
| 0.05 | 1.40 | 0.50 | - | - | - | - | - | - | - | - | - |

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 |
|---------------------------|-------------------------------------|---------------------------------------|----------------------|---|----------|
| PWHT 580 °C x 2 h/furnace | ≥ 410 | 500-600 | ≥ 22 | ≥ 55 | - |
| As Welded | ≥ 430 | 520-620 | ≥ 22 | ≥ 55 | - |

Gas test: Acc. To EN 439: C1(Arcal 2)

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

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 | 1,6 | | | |
|-----------|-----|-----|--|--|--|