

## Cored Wires C-Mn and low-alloy steels

Fluxofil 12 is a seamless copper coated rutile flux cored wire with a fast-freezing slag and outstanding characteristics when positional welding. Little spatter, easy slag removal producing smooth and finely rippled weld beads without undercut.

Classification	
AWS	A5.20: E71T-1 H4
EN	758:T 46 2 P C 1 H5

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
PRS	
RS	
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	1.20	0.55	-	-	-	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) 20 °C	Hardness
PWHT 580 °C x 2 h/furnace	≥ 460	550-650	≥ 22	≥ 80	-
As Welded	≥ 460	550-650	≥ 22	≥ 100	-

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

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

### Materials

S(P)235-S(P)460, GP240-GP280

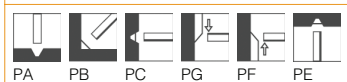
Shipbuilding steels A,B,D,E,AH32 to EH36

### Storage

Keep dry and avoid condensation

### Current condition and welding position

**DC+**



PA PB PC PG PF PE

**Packaging data:** K300 kg, 16

Diameters	1,2	1,6				
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