

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

Fluxofil 13 is a seamless copper coated rutile flux cored wire with a fast-freezing slag. Due to its easily controllable weld pool, it features excellent welding characteristics in all positions. Particularly suited for vertical welding on ceramic backing strips, for example, in shipbuilding and storage tank applications. Low spatter loss, easy slag removal, and pore-free, finely rippled welds are produced without undercut.

Classification	
AWS	A5.20: E 71T 1- H4
EN	758: T 46 2 P C 1 H5

Approvals	Grades
ABS	
BV	
DNV	
GL	
LRS	
RS	

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	0.40	-	-	-	-	-	-	-	-	-

### 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	≥ 0	-
As Welded	≥ 460	550-650	≥ 22	≥ 50	-

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

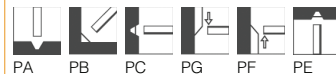
Shipbuilding steels A,B,D,E,AH32 to EH36

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg. 16

Diameters	1,2	1,6				