

# FLUXOFIL 16

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

Fluxofil 16 is a seamless copper coated rutile flux cored wire producing an excellent weld bead appearance. Easy slag removal, stable, practically spatter-free arc. Applications include structures with low temperature applications, to -20°C.

Classification	
AWS	A5.20: E71T-1M H4
EN	758: T 42 0 P C 1 H5

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.04	1.40	0.45	≤ 0.020	≤ 0.020	-	-	-	-	-	-	-

### 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
As Welded	≥ 420	500-640	≥ 20	≥ 47	-

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

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

### Materials

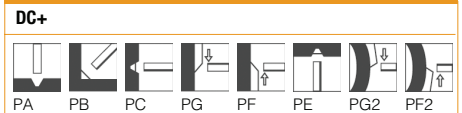
S(P)235-S(P)420, GP240-GP280

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

### Storage

Keep dry and avoid condensation

### Current condition and welding position



**Packaging data:** K300 kg, 16

Diameters	1,0	1,2	1,4	1,6		