

Cored Wires C-Mn and low-alloy steels

Fluxofil 20 is a seamless copper coated rutile flux cored wire with a fast-freezing slag, producing a weld metal with excellent mechanical-technological properties and a hydrogen content of < 5 ml per 100g deposited weld metal. Easily controllable weld pool and outstanding welding properties in all positions. Fluxofil 20 is particularly suitable for the fully mechanized welding of girth seams in pipelines by means of the orbital welding unit Citotrack OSG-01. For orbital MAG- welding the 6 to 12 o'clock position is preferred using with 1,2 to 1,4 mm dia. wire. Low spatter loss, easy slag removal producing finely rippled, pore-free welds without undercut.

Classification	
AWS	A5.29: E81T1-Ni1M JH4
EN	758: T 46 4 1Ni P M 1 H5

Approvals	Grades
ABS	
BV	
DB	
GL	
LRS	
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	0.50	-	-	-	0.90	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
PWHT 580 °C x 2 h	≥ 490	570-670	≥ 22	≥ 47	-
As Welded	≥ 490	570-670	≥ 22	≥ 60	-

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)275-S(P)460

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg, 16

Diameters	1,0	1,2	1,6			