

FLUXOFIL 31S

Cored Wires C-Mn and low-alloy steels

Fluxofil 31S is a seamless copper coated basic flux cored wire and is a slag-reduced version of Fluxofil 31, producing weld metal with excellent mechanical properties. Suitable for depositing very crack resistant and tough welded joints, especially when welding steels having a higher carbon content. Pore-free welds, easy slag removal.

Classification	
AWS	A5.20: E70T-5J H4 / E70T-5MJ H4
EN	758: T 42 4 B C 3 H5 / T 42 4 B M 3 H5

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.40	0.35	-	-	-	-	-	-	-	-	-

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	≥ 400	490-590	≥ 22	≥ 47	-
PWHT 940 °C x 0,5 h	≥ 280	420-520	≥ 30	-	-
As Welded	≥ 420	510-610	≥ 22	≥ 47	-

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