

Cored Wires C-Mn and low-alloy steels

Fluxofil 44 is a seamless copper coated basic flux cored wire for the welding of fine grain structural steels, and cryogenic steel grades. The weld metal meets high toughness mechanical property requirements in both the as-welded and stress relieved conditions. Quiet and smooth operation and low spatter loss with easy slag removal produces uniform and smooth weld beads which are free from porosity.

Classification	
AWS	A5.29: E70T5-GM JH4
EN	758: T 42 6 2Ni 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	0.90	0.30	-	-	-	2.50	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 80 °C	Hardness
PWHT 580 °C x 2 h	≥ 420	500-600	≥ 26	≥ 47	-
As Welded	≥ 440	520-620	≥ 26	≥ 47	-

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)420

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg, 16

Diameters	1,2	1,6				
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