FLUXOFIL 43.1

OERLIKON

Cored Wires
C-Mn and low-alloy steels

Fluxofil 43.1 is a seamless copper coated basic flux cored wire used for the welding of high-strength fine grain structural steels which are normalized (N) or normalized + tempered (N + T) after welding. The heat treatment required depends on the base metal being welded.The weld metal is not recommended for use in the as-welded or stress relieved conditions. Quiet and smooth running with low spatter loss and easy slag removal produces uniform and smooth beads which are free from porosity.

Classification	Approvals	Grades
AWS A5.29: E80T5-G H4		

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.20	0.30	-	-	-	2	0.30	-	0.10	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
PWHT 940 °C x 40 min.	≥ 430	550-650	≥ 20	≥ 40	-
PWHT 940 °C x 40 min. + 580°C x 2h	≥ 480	570-670	≥ 20	≥ 50	-

Gas test: Acc. To EN 439: C1(Arcal 2)

Shielding Gas: Acc. To EN 439: C1(Arcal 2)

Materials

S(P)355-S(P)500

Storage	Current condition and welding position
Keep dry and avoid condensation	**DC+**  PA PB PC

Packaging data: K300 kg. 16

Diameters	1,2					