

Cored Wires C-Mn and low-alloy steels

Fluxofil 40 is a seamless copper coated basic flux cored wire suitable for the welding of fine grain structural steels. Welded joints are resistant to cracking and free from porosity. Operating features include low spatter loss, easy slag removal and uniform bead appearance.

Classification	
AWS	A5.29: E80T5-G H4 / E80T5-GM H4
EN	758: T 46 6 1Ni B C 3 H5
EN	758: T 46 6 1Ni B M 3 H5

Approvals	Grades
DB	
DNV	
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	1.40	0.40	-	-	-	1.20	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
PWHT 580 °C x 2 h	≥ 460	520-620	≥ 24	≥ 47	-
As Welded	≥ 470	540-640	≥ 24	≥ 47	-

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

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

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	1,2	1,4	1,6			