

# FLUXOFIL 140 mod.

## Cored Wires C-Mn and low-alloy steels

Fluxofil 140 mod. is a seamless copper coated basic flux cored wire for the welding of high-strength fine grain structural steels. Used on DC-, negative pole, when positional welding. The maximum nickel content of 1,0 % indicates suitability for welding components for sour-gas installations. FLUXOFIL 140 mod. is CTOD tested for offshore applications.

Classification	
AWS	A5.29: ~ E81T1-Ni1M JH4
EN	758: T 46 6 Z B M 2 H5

Approvals	Grades
DNV	
LRS	
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
0.07	1.40	0.50	-	-	-	≤ 1	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
PWHT 580 °C x 2 h	≥ 460	540-640	≥ 21	≥ 47	-
As Welded	≥ 470	560-660	≥ 21	≥ 47	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal 21-Atal 6)

### Materials

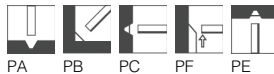
S(P)235-S(P)460, GP240-GP280

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



**Packaging data:** K300 kg, 16

Diameters	1,2					
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