

## Cored Wires High-strength steels

Fluxofil 41 is a seamless copper coated basic flux cored wire for the welding of high-strength fine grain structural steels. Operating features include low spatter loss, easy slag removal and uniform bead appearance.

Classification	
AWS	A5.29: E90T5-G H4 / E90T5-GM H4
EN	12535: T 55 6 1NiMo B C 3 H5
EN	12535: T 55 4 1NiMo B M 3 H5

Approvals	Grades
BWB	
DB	

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	0.40	-	-	-	-

### 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) - 40 °C	Hardness
PWHT 580 °C x 2 h	≥ 540	630-710	≥ 20	≥ 47	-
As Welded	≥ 560	650-750	≥ 20	≥ 80	-

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

**Shielding Gas:** Acc. To EN 439: M21(Arcal 21) or C1(Arcal 2)

### Materials

S(P)460-S(P)500, S550, HY 80

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg, 16

Diameters	1,2	1,4	1,6			
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