

## Cored Wires High-strength steels

Fluxofil 42 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: E110T5-K4 H4 / E110T5-K4M H4
EN	12535: T 69 6 Mn2NiCrMo B C 3 H5
EN	12535: T 69 6 Mn2NiCrMo B M 3 H5

Approvals	Grades
ABS	
BV	
BWB	
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	1.30	0.40	-	-	0.40	2.40	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	≥ 670	760-840	≥ 17	≥ 47	-
As Welded	≥ 690	760-900	≥ 17	≥ 80	-

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

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

### Materials

S620, S690, HY 100

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg. 16

Diameters	1,2					
-----------	-----	--	--	--	--	--