

# FLUXOFIL 42 LT

## Cored Wires High-strength steels

Fluxofil 42 LT is a seamless copper coated basic flux cored wire alloyed with Cr-Ni-Mo. Used for applications requiring very high yield strength and impact toughness values at low temperatures. Suitable for steels such as S690. Suitable for welding in all positions. To be used with Ar/CO<sub>2</sub> shielding gas.

### Classification

### Approvals

### Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.60	0.40	≤ 0.015	≤ 0.015	0.30	2.40	0.45	-	-	-	-

### 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) -50°C	Hardness
As Welded	≥ 690	760-900	≥ 15	≥ 47	-

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

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

### 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					
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