

Cored Wires High-strength steels

Fluxofil 45 is a seamless copper coated basic flux cored wire for welding high-strength fine grain structural steels. Quiet and smooth running with low spatter loss and easy slag removal producing uniform and smooth beads which are free from porosity. The mechanical properties of the weld depend on the cooling conditions and are influenced by the heat input and interpass temperature.

Classification	
EN	12535: T 89 4 Mn2Ni1CrMo B M 3 H5

Approvals	Grades
DB	
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
0.06	1.70	0.50	-	-	1	1.80	0.40	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
As Welded	≥ 890	980-1100	≥ 15	≥ 47	-

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

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

Materials

S890

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB PC

Packaging data: K300 kg. 16

Diameters	1,2					
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