

Cored Wires High-strength steels

Fluxofil 70 is a seamless copper coated basic flux cored wire for the joining and surfacing of stamping and pressing tools, dies, rolls and other components made of corresponding steel grades. The weld metal is developed for hardening and tempering and the mechanical properties are a function of the heat treatment.

Classification

AWS A5.29: E110T5-G H4 / E110T5-GM H4

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.10	0.40	-	-	1	2.20	1	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
PWHT 640 °C x 2 h	≥ 700	800-900	≥ 14	≥ 50	-

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

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

Materials

28 NiCrMo 44, 28 NiCrMo 74, 34 CrMo 4, 28 NiCrMo 4, 34 CrNiMo 6, 30 CrNiMo 8

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg, 16

Diameters	1,4	1,6				
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