

FLUXOFIL M42

Cored Wires High-strength steels

Fluxofil M42 is a seamless copper coated metal cored wire with outstanding welding characteristics in the short-arc and spray-arc ranges. Almost spatter-free when welding in the spray-arc range. Good restriking, even with a cold wire tip, thus being suitable for robotic applications. Characteristic features: good side wall fusion, smooth and finely rippled welds without undercut into the base metal. Little formation of silicates on the weld surface, so that multi-pass welds can be made without inter-run cleaning. Due to the easily controllable weld pool in the short-arc range, Fluxofil M 42 is suitable for positional welding.

Classification	
AWS	A5.28: E110C-G H4
EN	12535: T 69 4 Mn2NiCrMo M M 1 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
0.05	1.60	0.50	-	-	0.45	1.90	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
PWHT 580 °C x 2 h	≥ 690	760-850	≥ 15	≥ 47	-
As Welded	≥ 690	760-850	≥ 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+				
				
PA	PB	PC	PF	PE

Packaging data: K300 kg. 16

Diameters	1,2					
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