

# FLUXOFIL 48

## Cored Wires Weathering steels

Fluxofil 48 is a seamless copper coated basic flux cored wire for the welding of weathering and fine grain structural steels. The weld metal is resistant to atmospheric corrosion. Low spatter loss, easy slag removal, smooth and uniform bead appearance.

Classification	
AWS	A5.29: E80T5-G H4 / E80T5-GM H4
EN	758: T 46 6 Z B C 3 H5
EN	758: T46 6 Z 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
0.05	1.20	0.40	-	-	-	1.20	-	-	-	-	0.50

### 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) - 60 °C	Hardness
As Welded	≥ 460	540-640	≥ 24	≥ 47	-

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

**Shielding Gas:** Acc. To EN 439: C1(Arcal 2) or M21(Arcal21-Atal6)

### Materials

S235J0W; S235J2W; S355J0W; S355J2W; S355K2W

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg. 16

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