

FLUXOFIL M 48

Cored Wires Weathering steels

Fluxofil M 48 is a seamless copper coated metal cored wire. Alloyed with Cu-Ni-Cr for single or multipass applications. Suitable for joining high tensile steels and corrosion resistant steels. To be used with Ar/CO₂ gas shielding.

Classification	
AWS	A5.29: E81TG-W2M

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.20	0.50	≤ 0.020	≤ 0.020	0.50	0.45	-	-	-	-	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) -30°C	Hardness
As Welded	≥ 470	550-690	≥ 24	≥ 27	-

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

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

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					
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