

# FLUXOFIL 464M

## TOP FEATURES

- FLUXOFIL 464M is rutile seamless copper coated flux cored wire for welding of steel with Re up to 460MPa and meets impact requirements at -40°C
- The wire is characterized by reduced emission of welding fumes.
- Excellent operator appeal due to new flux formulation and exceptional arc stability.
- Very good performance in vertical up welding, including root passing on ceramic backing.

## CLASSIFICATION

AWS A5.20 E71T-1M-JH4  
 EN ISO 17632-A T 46 4 P M21 1 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All position, except vertical down

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO<sub>2</sub>

## APPROVALS

ABS	LR	BV	DNV	RINA	TÜV	DB	CWB
+	+	+	+	+	+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.07	1.5	0.5	≤0.010	≤0.010

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	M21	AW	≥460	≥550	≥23	≥76

\* AW = As welded

Gas test: 82% Ar + 18% CO<sub>2</sub>

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	W000424203
	SPOOL (BS300)	16.0	W000414203

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.