

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 17634-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% CO₂

APPROVALS

LR	RINA	TÜV
+	+	+

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

C	Mi	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% CO₂

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	W000424203
	SPOOL (B300)	16.0	W000404203
	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 for any updated information.