

# FLUXOFIL 42

## TOP FEATURES

- Seamless basic flux cored wire for gas shielded metal arc welding of high-strength fine grain structural steels with minimum yield strength of 690 MPa and impact toughness at -60°C.
- Very stable mechanical properties thanks to precisely controlled chemical composition and basic slag system.
- Good productivity and high purity of weld metal.

## TYPICAL APPLICATIONS

- Offshore
- Steel construction

## CLASSIFICATION

AWS A5.29 E110T5-K4M-H4  
 EN ISO 18276-A T 69 6 Mn2NiCrMo B M21 2 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

DNV	TÜV	DB
+	+	+

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

C	Mn	Si	P	S	Cr	Ni	Mo
0.06	1.5	0.3	0.01	0.01	0.4	2.3	0.4

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-40°C	-60°C
Typical values	M21	AW	≥690	770-895	≥17	≥80	≥47
		580°C x 2 h	≥690	770-895	≥17	≥80	≥47

\* 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 (B300)	16.0	W000281205
1.6	SPOOL (B300)	16.0	W000281207

## 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.