FLUXOFIL M10

TOP FEATURES

- Seamless copper coated metal cored wire for welding of steel with Re up to 460MPa and very good impact properties at -40°C
- Better tolerance of variable gap and surface conditions in relation to MAG process
- Very good weldability with short, pulsed and spray arc. Suitable for robotic applications
- Bridging and root passing capabilities with short and pulsed arc

CLASSIFICATION

AWS A5.18	E70C-6M H4
EN ISO 17632-A	T 46 4 M M21 1 H5
EN ISO 17632-B	T494T15-1MA-UH5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

APPROVALS

ABS, LR, BV, DNV, TÜV, DB, CWB

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2

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

C	Mn	Si	P	S
0.08	1.5	0.4	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	580°C x 2 h/furnace	≥460	550-680	≥24	≥80
		AW	≥460	550-680	≥24	≥60

* AW = As welded

Gas test: 82% Ar + 18% CO_2

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (B300)	16.0	W000281014
1.2	SPOOL (B300)	16.0	W000281017
	SPOOL (BS300)	16.0	W000381017
	DRUM	200.0	W000281019

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.