



OERLIKON

www.oerlikon-welding.com



FLUXOFIL
THE ORIGIN OF SEAMLESS CORED WIRES

FLUXOFIL the Original since 1968

FLUXOFIL seamless Tubular cored wires meet your highest **weldability and reliability** expectations through precisely selected micro alloying elements and unique production processes.

OERLIKON, more than
50 YEARS* OF EXPERTISE
in Seamless Flux Cored Wire production.



**1968 - patent and production of the first seamless wires*

OERLIKON seamless copper coated wires are widely applied in industry for welding of **Re 355-890 MPa** steels.



- **Resistant against harsh storage** conditions
- **Outstanding wire feeding** combined with **stable arc**
- **Low hydrogen** and reduced risk of cold cracking, delivering highest quality levels
- **Excellent slag removal** and regular bead appearance
- **Superior welding productivity**



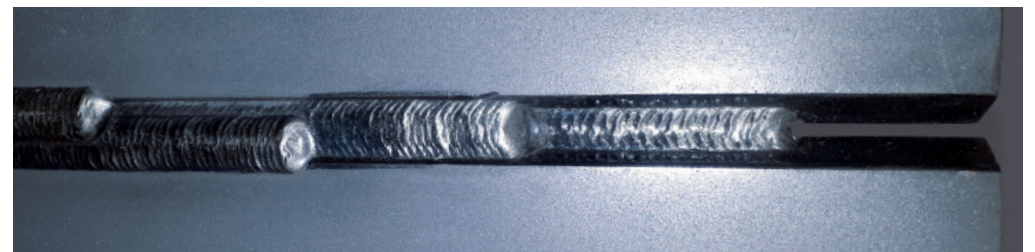
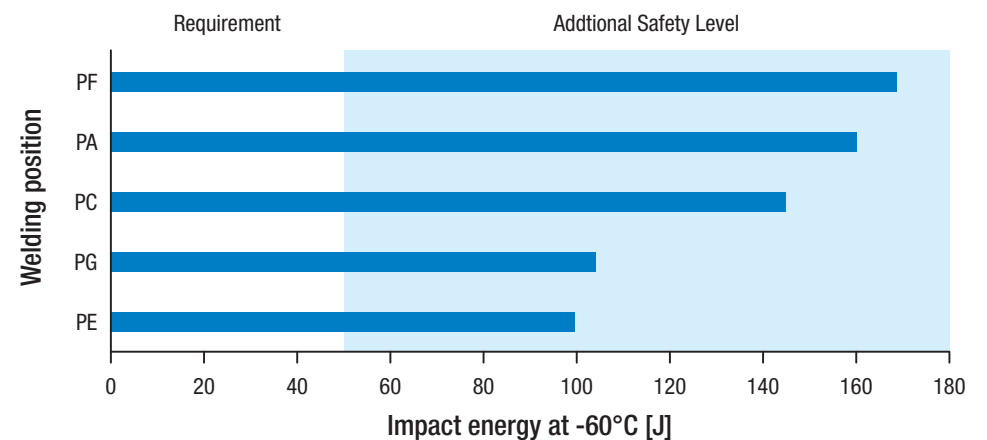
The Latest Production Technology

New market requirements call for base materials and welding products delivering highest yield strengths and impacts at low temperatures.

Such demanding applications require **outstanding consistency of mechanical properties** combined with **superior welding performance and productivity**.

- **Best in class deposition rate** combined with exceptional arc stability and operability
- Very good results of **low temperature impact**. Alloying and micro-alloying elements are precisely selected and controlled during wire fill and rolling processes
- Consumable and flux **homogeneity**

Impact test results, Fluxofil MC466M, 20mm plate, V60 joint preparation



Technical data

Product name		Type	Gas	AWS 5.36	EN ISO 17632-A/18276-A /17634-A
Mild Steels 275MPa<Re<460Mpa					
Fluxofil 14 HD		R	M21/C1	E71T1-C1A0-CS1-H4 E71T1-M21A2-CS1-H4	T 46 3 P M 1 H5 T 46 3 P M 1 H5
Fluxofil 19 HD		R	C1	E71T1-C1A2-CS1-H4	T 46 3 P C 1 H5
Fluxofil M 8		MC	M21	E71T15-M21A2-CS1-H4	T 46 2 M M 1 H5
High Strength Steels 355MPa<Re<460MPa, impact at -40°C and -60°C					
Fluxofil 464M		R	M21	E71T1-M21A4-CS1-H4	T 46 4 P M 1 H5
Fluxofil 20 HD	Impact at -40°C	R	M21	E81T1-M21A4-Ni1-H4	T 46 4 1Ni P M 1 H5
Fluxofil 21 HD	Impact at -40°C	R	C1	E81T1-C1A4-Ni1-H4	T 46 4 1Ni P C 1 H5
Fluxofil M 10	Impact at -40°C	MC	M21	E71T15-M21A4-CS1-H4	T 46 4 M M 1 H5
Fluxofil 31	Impact at -40°C	B	M21/C1	E70T5-M21A4-M21S1-H4 E70T5-M21A4-CS1-H4	T 42 4 B M 2 H5 T 42 4 B C 2 H5
Fluxofil M 10 S	Impact at -60°C	MC	M21	E71T15-M21A8-CS1-H4	T 42 6 M M 1 H5
Fluxofil 40	Impact at -60°C	B	M21	E80T5-M21A4-GH4	T 46 6 1Ni B M 2 H5
Fluxofil MC466M	Impact at -60°C	MC	M21	E71T15-M21A8-CS1-H4	T 46 6 M M 1 H5
Ultra High Strength Steels					
Fluxofil 41	Re 550 MPa	R	M21/C1	E90T5-C1A0-GH4 E90T5-M21A0-GH4	T 55 4 1NiMo B C 2 H5 T 55 4 1NiMo B C 2 H5
Fluxofil M 41	Re 550 MPa	MC	M21	E90T15-M21A5-G-H4	T 55 5 Z M M 1 H5
Fluxofil 29 HD	Re 690 MPa	R	M21	E111T9-M21A2-GH4	T 69 4 Z P M 1 H5
Fluxofil M 42	Re 690 MPa	MC	M21	E110T15-M21A2-G-H4	T 69 4 Mn2NiCrMo M M 1 H5
Fluxofil 42	Re 690 MPa	B	M21	E110T5-M21A4-K4H4	T 69 6 Mn2NiCrMo B M 2 H5
Fluxofil 45	Re 890 MPa	B	M21	E130T5-M21A4-GH4	T 89 4 Z B M 2 H5
Weathering Steels					
Fluxofil 48	Re 460 MPa	B	M21	E80T5-M21A0-GH4	T 46 6 Z B M 2 H5
Fluxofil M 48	Re 460 MPa	MC	M21	E81T15-M21A0-W2-H4	T 46 3 Z M M 1 H5
Fluxofil 18 HD	Re 500 MPa	R	M21	E81T1-M21A0-G-H4	T 50 3 Z P M 1 H5
Cr-Mo Steels					
Fluxofil 25	Mo	R	M21	E81T1-M21PY-A1-H4	T MoL P M 1 H5
Fluxofil 35	Mo	B	C1/M21	E80T5-M21PY-GH4 E70T5-C1PY-GH4	T MoL B C 2 H5 T MoL B M 2 H5
Fluxofil 36	CrMo1	B	C1/M21	E80T5-M21PY-B2H4 E80T5-C1PY-B2H4	T CrMo1 B M 2 H5 T CrMo1 B C 2 H5
Fluxofil 37	CrMo2	B	C1/M21	E80T5-M21PY-GH4 E80T5-C1PY-GH4	T CrMo2 B M 2 H5 T CrMo2 B C 2 H5

R: Rutile - B: Basic - MC: Metal Cored

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