

# FLUXOFIL 70

## TOP FEATURES

- Seamless copper coated basic flux cored wire for the joining and surfacing of stamping and pressing tools.
- The weld metal is developed for hardening and tempering and the mechanical properties are a function of the heat treatment.

## TYPICAL APPLICATIONS

- Maintenance and repair.

## CLASSIFICATION

AWS A5.36 E120T5-GM-H4  
 EN ISO 18276-A T 69 A Z B M21 3 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

Flat/Horizontal

## SHIELDING GASES (ACC. EN ISO 14175)

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

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

C	Mn	Si	Cr	Ni	Mo
0.08	1.1	0.4	1	2.2	1

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20 °C
Typical values	M21	640 °C x 2 h	≥745	827-940	≥17	≥50

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

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.4	SPOOL (B300)	16.0	W000281224

### 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.