

Cored Wires C-Mn and low-alloy steels

FLUXOFIL M10 is a seamless copper coated metal cored wire with outstanding welding properties in the short-arc and spray-arc ranges depositing slag free weld metal. Almost spatter-free when welding in the spray-arc range. Good restriking, even with a cold wire tip, thus being suitable for robotic applications. Characteristic features: good side wall fusion, smooth and finely rippled welds without undercut into the base metal. Little formation of silicates on top of weld, so that multi-pass welds can be made without inter-run cleaning. Due to an easily controllable weld pool in the short-arc range, FLUXOFIL M 10 is well-suited for root- and positional welding.

| Classification | |
|----------------|--------------------------|
| EN ISO | 17632-A: T 46 4 M M 1 H5 |
| EN ISO | 17632-B: T554T15-1MA-UH5 |
| AWS | A5.18: E70C-6M H4 |

| Approvals | Grade |
|-----------|----------------|
| ABS | 4YSA H5 |
| BV | SA3Y M H5 KV40 |
| DB | ● |
| DNV | IVY40MS H5 |
| GL | 4YH5S |
| LRS | 4Y40S H5 |
| TÜV | ● |

CE

Chemical analysis (Typical values in %)

| C | Mn | Si | P | S |
|------|-----|-----|-------|-------|
| 0.08 | 1.5 | 0.4 | 0.010 | 0.010 |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength (MPa) | Tensile Strength (MPa) | Elongation A5 (%) | Impact Energy ISO - V (J) |
|---------------------|----------------------|------------------------|-------------------|---------------------------|
| | | | | -40 °C |
| 580°C x 2 h/furnace | ≥ 460 | 550-680 | ≥ 24 | ≥ 80 |
| As Welded | ≥ 460 | 550-680 | ≥ 24 | ≥ 60 |

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M21

Materials

S(P)235-S(P)460, GP240-GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

| Packaging Type | B300 | DRUM |
|-----------------------|------|------|
| Diam(mm) / weight(kg) | 16 | 200 |
| 1.0 | ● | |
| 1.2 | ● | ● |
| 1.6 | ● | ● |