

FLUXOFIL M10S is a seamless copper coated metal cored wire producing no slag, for welding with both the single and multi-run techniques. Excellent weldability, high deposition rate, very good impact toughness at low temperatures, down to -60°C, both as welded and following post-weld heat treatment. Suitable for applications where very high toughness properties are required.

Classification

EN ISO	17632-A: T 42 6 M M 1 H5
EN ISO	17632-B: T496T15-1MA-UH5
AWS	A5.18: E70C-6M H4
AWS	A5.36: E71T15-M21A8-CS1-H4

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	1.6	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)
				-60 °C
As Welded	≥ 420	500-640	≥ 26	≥ 60
620°C x 1h	≥ 420	500-640	≥ 27	≥ 80

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M21

Materials

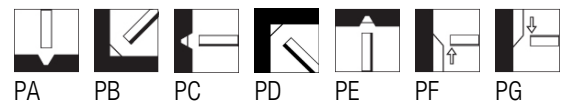
S(P)235-S(P)420, GP240-GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B300	DRUM
Diam(mm) / weight(kg)	16	200
1.2	W000281027	W000281028