

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: T494T15-1MA-UH5
AWS	A5.18: E70C-6M H4
AWS	A5.36: E71T15-M21A4-CS1-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

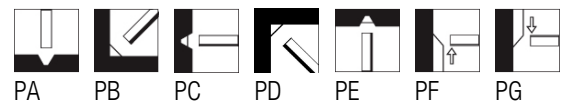
S(P)235-S(P)460, GP240-GP280

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	W000281014	
1.2	W000281017	W000281019
1.6	W000281022	W000281024