

FLUXOFIL M 48 is a seamless copper coated metal flux cored wire for gas-shielded metal arc welding of weathering and fine grain structural steels such as Patinax or Cor-ten. The weld metal is resistant to atmospheric corrosion. The weld metal corrosion behaviour is adapted to these steel types. Stable operating characteristics in short, spray and pulsed arc applications alike. Safe side wall fusion and very good gap bridging characteristics. To be used with Ar/CO₂ gas shielding.

Classification

EN ISO	17632-A: T 46 3 Z M M 1 H5
AWS	A5.36: E81T15-M21A0-W2-H4

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Cu
0.05	1.1	0.4	≤ 0.020	≤ 0.020	0.6	0.5	0.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-30 °C
As Welded	≥ 470	550-680	≥ 24	≥ 47

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : M21

Materials

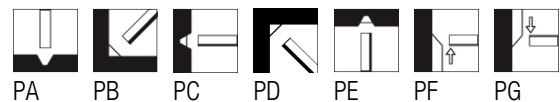
S235J0W; S235J2W; S355J0W; S355J2W; S355K2W

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16.0
1.2	W000281193
1.4	W000281194