

FLUXOFIL MC466M is the seamless copper coated metal cored wire for welding with M21 gas. It is designed for welding of steels with Re 355-460 MPa and meets impact requirements at -60°C. Excellent weldability for single and multipass welds in semiautomatic and robotic applications. Exceptional performance cause of new formula and optimized fill ratio. Applicable for welding on CV and Pulse welding modes. Weld metal is characterized by very low content of diffusible Hydrogen- below 4 ml/100g.

NEW

Classification	
EN ISO	17632-A: T 46 6 M M 1 H5
AWS	A5.18: E70C-6M H4
AWS	A5.36: E70T15-M21A8-CS1-H4

Approvals	Grade
ABS	5Y460
BV	SA5Y46 H5
CWB	E490T15-M21A6-CS1-H4
DNV-GL	V Y46MS(H5)
LR	Pending
RINA	5Y46
TUV/DB	in development

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.06	1.40	0.55	≤ 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	>460	≥ 550	≥ 25	≥ 50
620°C/2h	>420	>500	≥ 30	≥ 60

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M21

Materials

S235-S460 M/N L

Shipbuilding steels A, B, D, DH, F, FH VL E,F 32 - 46

X42 - X65

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B300	BS300	S200
Diam(mm) / weight(kg)	16	16	5
1.2	W000404204		W000414204
1.4		W000404206	