

PRODUCT DATA SHEET

Oerlikon Fluxofil M10



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 M10 is well suited for root and positional welding.

Storage

Keep dry and avoid condensation.

Classifications

AWS	A5.18	E70C-6M H4
EN	I7632-A	T 46 4 M M I H5

Approvals

American Bureau of Shipping	Germanischer Lloyd
Bureau Veritas	Lloyds Register of Shipping
DB	TÜV
Det Norske Veritas	UDT

Typical Chemical Analysis (All weld metal)

% Carbon	0,06	% Silicon	0,6
% Manganese	1,3		

Typical Mechanical Properties (All weld metal)

Heat Treatment	As Welded	PWHT 580°C x 2 hr/furnace
Yield Strength N/mm ²	≥460	≥460
Tensile Strength N/mm ²	550 - 660	550 - 660
% Elongation on A5	≥24	≥24
Impact Energy at -20°C	≥47 J	≥47 J

Gas Test	Afrox Fluxshield®
Shielding Gas	Afrox Fluxshield®
Materials	S(P)460-S(P)500, S550, HY 80

Packing Data

Diameter (mm)	Item Number
1,6	W125412

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