

## MIG/MAG Cored Wires C-Mn and low-alloy steels

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: T554T15-1MA-UH5
AWS	A5.18: E70C-6M 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

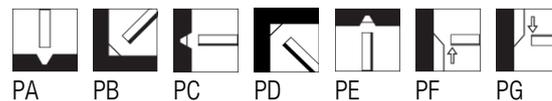
S(P)235-S(P)460, GP240-GP280

#### 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	●	
1.2	●	●
1.6	●	●