

# FLUXOFIL M 42

## TOP FEATURES

- Seamless copper coated metal cored wire for welding of high strength steels with minimum yield strength of 690 MPa.
- Due to the easily controllable weld pool in the short-arc range, FLUXOFIL M 42 is suitable for positional welding both on CV and pulse modes.
- Higher deposition rate and more regular weld profile comparing to MAG welding with solid wires.
- Very good weldability with short, pulsed and spray arc. Suitable for robotic applications.
- Meets AWS A5.28: E110C-GM H4.

## TYPICAL APPLICATIONS

- Steel construction.
- Transportation.

## CLASSIFICATION

AWS A5.29 E110C-GM H4  
EN ISO 18276-A T 69 4 Mn2NiCrMo M M 1 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ >15-25% CO<sub>2</sub>

## APPROVALS

ABS	LR	BV	DNV	TÜV	DB
+	+	+	+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni	Mo
0.05	1.5	0.5	0.01	0.01	0.4	2	0.4

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	M21	580°C x 2 h/furnace (**)	≥690	770-896	≥17	≥80
	M21	AW(***)	≥690	770-896	≥17	≥80

\* AW = As welded

Gas test: M21 (\*\*), 82% Ar+ 18% CO<sub>2</sub> (\*\*\*)

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000281216
	DRUM	200.0	W000281217
1.6	SPOOL (B300)	16.0	W000281219

#### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
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