

# FLUXOFIL 31

## TOP FEATURES

- General purpose seamless copper coated basic flux cored wire. High quality welds with good slag removal.
- Weld metal with very low content of diffusible hydrogen (HD< 3 ml/100g deposited weld metal)
- Excellent mechanical properties and purity of weld metal.

## CLASSIFICATION

AWS A5.20	E70T-5C-JH4
	E70T-5M-JH4
EN ISO 17632-A	T 42 4 B M 2 H5
	T 42 4 B C 2 H5
EN ISO 17632-B	T494T5-1CA-UH5
	T494T5-1MAUH5

## CURRENT TYPE

DC-

## WELDING POSITIONS

All position, except vertical down

## SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO <sub>2</sub>
M21	Mixed gas Ar+ >15-25% CO <sub>2</sub>

## APPROVALS

ABS	LR	BV	DNV	RMRS	PRS	TÜV	DB
+	+	+	+	+	+	+	+

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

C	Mn	Si	P	S
0.05	1.2	0.3	≤0.010	≤0.010

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	C1	AW	≥420	500-640	≥25	≥80

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (B300)	16.0	W000281163
1.2	SPOOL (B300)	16.0	W000281166
	DRUM	200.0	W000281167
1.6	SPOOL (B300)	16.0	W000281169

### 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.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.