FLUXOFIL 31S

TOP FEATURES

- General purpose seamless copper coated basic flux cored wire with optimized slag solidification rate.
- Pore-free welds, easy slag removal.
- Suitable for depositing very crack resistant and tough welded joints, especially when welding steels having a higher carbon content

CLASSIFICATION

AWS A5.20	E70T-5C-JH4
	E70T-5M-JH4
EN ISO 17632-A	T 42 4 B M21 2 H5
	T 42 4 B C1 2 H5
EN ISO 17632-B	T494T5-1MAUH5
	T494T5-1CA-UH5

CURRENT TYPE

DC-

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO_2
M21	Mixed gas Ar+ >15-25% CO_2

APPROVALS

ABS	BV	DNV	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
1.2	SPOOL (B300)	16.0	W000281172
1.6	DRUM	200.0	W000281176

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 for any updated information.