

# FLUXOFIL 45

## TOP FEATURES

- Seamless copper coated basic flux cored wire for welding high-strength structural steels with Re up to 890 MPa.
- Very stable mechanical properties thanks to precisely controlled chemical composition and basic slag system.

## TYPICAL APPLICATIONS

- Welding of extra high strength steels

## CLASSIFICATION

AWS A5.29 E120T5-GM-H4  
EN ISO 18276-A T 89 4 Z B M21 2 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All position, except vertical down

## SHIELDING GASES (ACC. EN ISO 14175)

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

## APPROVALS

TÜV	DB
+	+

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

C	Mn	Si	P	S	Cr	Ni	Mo
0.09	2	0.5	0.01	0.01	1	1.8	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	AW	≥890	940-1034	≥15	≥47

\* AW = As welded

Gas test: 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	W000281221

## 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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