

FLUXOFIL 35

Růrkový drôt s bázickou náplňou pre zváranie MAG
Basic tubular cored electrode for MAG-welding
Zasadový drut rdzeniowy bez szwu do spawania MAG



Standards:

DIN EN 12071
AWS/ASME SFA-5.29

T MoL B C 3 H5 / T MoL B M 3 H5
E80T5-G H 4 / E80T5-GM H 4

SK Vlastnosti a oblasť použitia:

Bázický rúrkový drôt, pre zváranie žiarupevných kotlových a potrubných ocelí pre prevádzkovú teplotu do 530 °C, pre jemnozrnné ocele. Kľudný a stabilný oblúk, minimálne straty rozstrekom, dobrá odstrániteľnosť trosky, čisté zvary, zvarový spoj bez pórov.

GB Applications and properties:

Basic tubular cored electrode suitable for welding of creep resistant boiler and pipe steels subjected to operating temperatures up to 530 °C, as well as fine grain structural steels. Quiet and stable arc, low spatter loss, easy slag removal, uniform and smooth weld surface, pore-free welds.

POL Zastosowania i własności:

Zasadowy drut rdzeniowy bez szwu przydatny do spawania odpornych na peźnienie stali kotłowych i rurowych, pracujących w temperaturze do +530°C, jak również drobnozrniastych stali konstrukcyjnych. Spokojny i stabilny łuk, niskie straty na rozprysk, łatwe usuwanie żuźla, jednolita i gładka powierzchnia spoiny, spoiny bez porów.

Materials for instance:

EN-Designation	DIN-Designation	EN-Designation	DIN-Designation
16Mo3	15 Mo 3	S(P)355 to S(P)460	StE 355 to StE 460

Approvals:

TÜV, TÜV Austria, DB, Controlas

Analysis of all-weld metal (typical values in %):

C	Si	Mn	Mo
0,05	0,40	1,40	0,50

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]	Impact energy ISO-V (Joule)			
				+20 °C	0 °C	-20 °C	-40 °C
AW	≥ 490	550–650	≥ 22	≥ 120	≥100	≥80	≥ 40
SR	≥ 470	520–620	≥ 22	≥ 120	≥100	≥80	≥ 40
N	≥ 310	450–550	≥ 28	≥ 140	–	–	–

AW = as-welded

SR = stress relieved (2 hrs./580 °C/furnace cooling to 300 °C)

N = normalized (30 min./940 °C/air cooling)

Chemical composition and mechanical properties apply to the use of shielding gas:

DIN EN 439 - C1 (100 Vol. % CO₂)

Hints on use of other shielding gases, see page B 56.

Shielding gas as to DIN EN 439:

C1 (carbon dioxide), M21 (ARCAL 21)

Consumption:

12–15 l/min for Ø ≤1,6 mm, 15–20 l/min for Ø ≥2,0 mm

Form of delivery:

Wire cage reel K300 (16 kg)			
Wire diameters [mm]	1,2	1,4	1,6

Further forms of delivery on request.

Type of current/Polarity/Welding positions:

