



OERLIKON

FLUXOFIL

*The origin of seamless
cored wires*

www.oerlikon-welding.com

FLUXOFIL the Original since 1968

FLUXOFIL seamless Tubular and **New Laser Technology (NLT)** cored wires meet your highest **weldability and reliability** expectations through precisely selected micro alloying elements and unique production processes.



OERLIKON, more than
50 years* of expertise

in Seamless Flux Cored Wire production.

*1968 – patent and production of the first seamless wires



FLUXOFIL seamless copper coated wires are widely applied in industry for welding of **Re 355-890 MPa** steels.

FLUXOFIL

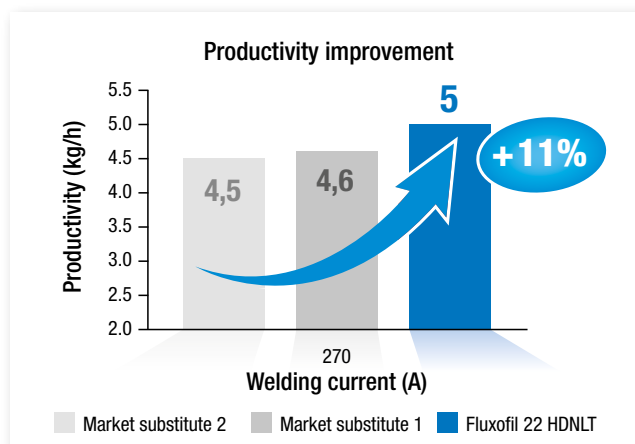
- ▣ **Resistant against harsh storage** conditions
- ▣ **Outstanding wire feeding** combined with **stable arc**
- ▣ **Low hydrogen** and reduced risk of cold cracking, delivering highest quality levels
- ▣ **Excellent slag removal** and regular bead appearance
- ▣ **Superior welding productivity**

The New Laser Technology is stretching the limits

New market requirements call for base materials and welding products delivering highest yield strengths and impacts at low temperatures. Such demanding applications require **outstanding consistency of mechanical properties** combined with **superior welding performance and productivity**.

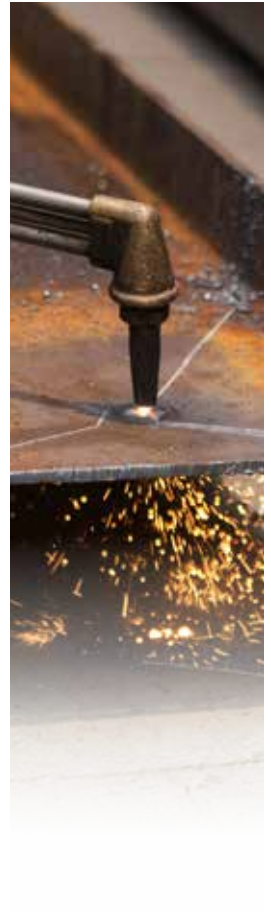
FLUXOFIL HD^{NLT}

- ▣ **Best in class deposition rate** combined with exceptional arc stability and operability
- ▣ Very good results of **low temperature impact**. Alloying and micro-alloying elements are precisely selected and controlled during wire fill and rolling processes
- ▣ **CTOD tested**
- ▣ Consumable and flux **homogeneity**



Technical data

Product name		Type	Gas	AWS 5.36	EN ISO 17632-A/18276-A
Welding of mild steels 275MPa<Re<460Mpa					
FLUXOFIL 14 HD	-	Rutile	Mix gas/CO ₂	E71T1-C1A0-CS1-H4 E71T1-M21A2-CS1-H4	T 46 3 P M 1 H5 T 46 3 P M 1 H5
FLUXOFIL 19 HD	-	Rutile	CO ₂	E71T1-C1A2-CS1-H4	T 46 3 P C 1 H5
FLUXOFIL M 8	-	Metal Cored	Mix gas	E71T15-M21A2-CS1-H4	T 46 2 M M 1 H5
Welding of High Strength steels 355MPa<Re<460MPa with impact at -40°C and -60°C					
FLUXOFIL 20 HD	Impact at -40°C	Rutile	Mix gas	E81T12-M21A4-Ni1-H4	T 46 4 1Ni P M 1 H5
FLUXOFIL 21 HD	Impact at -40°C	Rutile	CO ₂	E81T12-C1A4-Ni1-H4	T 46 4 1Ni P C 1 H5
FLUXOFIL M 10	Impact at -40°C	Metal Cored	Mix gas	E71T15-M21A4-CS1-H4	T 46 4 M M 1 H5
FLUXOFIL M 10 PG	Impact at -40°C	Metal Cored	Mix gas	E71T15-M21A4-CS1-H4	T 46 4 M M 1 H5
FLUXOFIL 31	Impact at -40°C	Basic	Mix gas/CO ₂	E70T5-M21A4-M21S1-H4 E70T5-M21A4-CS1-H4	T 42 4 B M 2 H5 T 42 4 B C 2 H5
FLUXOFIL M 10 S	Impact at -60°C	Metal Cored	Mix gas	E71T15-M21A8-CS1-H4	T 42 6 M M 1 H5
FLUXOFIL 40	Impact at -60°C	Basic	Mix gas	E80T5-M21A4-GH4	T 46 6 1Ni B M 2 H5
FLUXOFIL 22^{NLT}	Impact at -60°C	Rutile	Mix gas	E81T12-M21A8-Ni1-H4	T 46 6 Ni1 P M 1 H5
FLUXOFIL 23^{NLT}	Impact at -60°C	Rutile	CO ₂	E81T12-C1A8-Ni1-H4	T 46 6 Ni1 P C 1 H5
Welding of Ultra High Strength steels					
FLUXOFIL 41	Re 550 MPa	Rutile	Mix gas/CO ₂	E90T5-C1A0-GH4 E90T5-M21A0-GH4	T 55 4 1NiMo B C 2 H5 T 55 4 1NiMo B C 2 H5
FLUXOFIL M 41	Re 550 MPa	Metal Cored	Mix gas	E90T15-M21A5-G-H4	T 55 5 Z M M 1 H5
FLUXOFIL M 41 PG	Re 550 MPa	Metal Cored	Mix gas	E90T15-M21A6-K11-H4	T 55 4 Z M M 1 H5
FLUXOFIL 29 HD	Re 690 MPa	Rutile	Mix gas	E111T9-M21A2-GH4	T 69 4 Z P M 1 H5
FLUXOFIL M 42	Re 690 MPa	Metal Cored	Mix gas	E110T15-M21A2-G-H4	T 69 4 Mn2NiCrMo M M 1 H5
FLUXOFIL M 42 PG	Re 690 MPa	Metal Cored	Mix gas	E110T15-M21A2-G-H4	T 69 4 Mn2NiCrMo M M 1 H5
FLUXOFIL 42^{NLT}	Re 690 MPa	Basic	Mix gas	E110T5-M21A4-K4H4	T 69 6 Mn2NiCrMo B M 2 H5
FLUXOFIL 45	Re 890 MPa	Basic	Mix gas	E130T5-M21A4-GH4	T 89 4 Z B M 2 H5
Welding of Weathering Steels					
FLUXOFIL 48	Re 460 MPa	Basic	Mix gas	E80T5-M21A0-GH4	T 46 6 Z B M 2 H5
FLUXOFIL M 48	Re 460 MPa	Metal Cored	Mix gas	E81T15-M21A0-W2-H4	T 46 3 Z M M 1 H5
FLUXOFIL 18 HD	Re 500 MPa	Rutile	Mix gas	E81T1-M21A0-G-H4	T 50 3 Z P M 1 H5



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CUSTOMER ASSISTANCE POLICY

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