

FLUXOFIL M8 is a seamless copper coated metal cored wire with outstanding welding characteristics in short-arc and spray-arc ranges depositing slag free weld metal. Almost spatter-free when welding in the spray-arc range. Good restriking, even with a cold wire tip, thus being suitable for robotic applications. Characteristic features: high deposition rate and welding speed, good side wall fusion, finely rippled welds, without undercut into the base metal, even on contaminated or corroded metal surfaces. Little formation of silicates on the weld surface, so multi-pass welds can be made without inter-run cleaning. Due to an easily controllable weld pool in the short-arc range, FLUXOFIL M8 is well-suited for root- and positional welding and gap bridging.

Classification	
EN ISO	17632-A: T 46 2 M M 1 H5
EN ISO	17632-B: T552T15-1MA-UH5
AWS	A5.18: E70C-3M H4
AWS	A5.36: E71T15-M21A2-CS1-H4

Approvals	Grade
BV	SA3-3YM H5
DB	●
DNV	IIY40MS H5
GL	3Y40H5S
LRS	3Y40SH5
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	1.3	0.7	0.010	0.010

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-20 °C
As Welded	≥ 460	550-680	≥ 24	≥ 50


Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M21

Materials

S(P)235-S(P)460

Storage
Keep dry and avoid condensation

Current condition and welding position
DC+


Packaging data

Packaging Type Diam(mm) / weight(kg)	B300	DRUM
	16	200
1.0	W000281001	W000281002
1.2	W000281004	W000281006
1.4	W000281008	W000281009
1.6	W000281011	W000281012