

FLUXOFIL 464M is the seamless copper coated flux cored wire for welding with M21 gas. The wire is characterized by reduced emission of welding fumes with fume class 5b. The consumable is designed for welding of steels with Re 355-460 MPa and meets impact requirements at -40°C. Excellent operator appeal due to new flux formulation and exceptional arc stability. Very good performance in vertical up and positional welding, including root passing on ceramic backing. Weld metal is characterized by very low content of diffusible Hydrogen - below 4 ml/100g.

NEW

Classification

EN ISO	17632-A: T 46 4 P M21 1 H5
AWS	A5.20: E71T-1M-JH4
AWS	A5.36: E71T1-M21A4-CS1-H4

Approvals

Approvals	Grade
ABS	4Y400
BV	SA4Y46 H5
CWB	E491T1-M21A4-CS1-H4
DNV-GL	IV Y40MS(H5)
LR	4Y46S H5
RINA	4Y40
TUV/DB	pending

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	1.5	0.5	≤ 0.010	≤ 0.010

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-40 °C
As Welded	≥ 460	≥ 550	≥ 23	≥ 76

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M21

Materials

S(P)235-S(P)460M/N

Shipbuilding steels D, E, EH, VL E 32 - 46

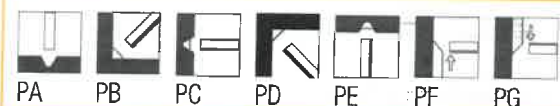
X42 - X65

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B300	BS300	S200
Diam(mm) / weight(kg)	16	16	5
	W000404203	W000414203	W000424203