

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

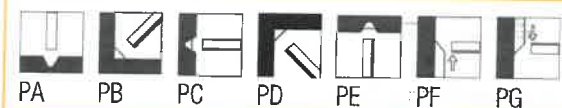
X42 - X65

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 |