

FLUXOFIL 41

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



Standards: DIN EN 12535
AWS/ASME SFA-5.29

T 55 6 1NiMo B C 3 H5
T 55 4 1NiMo B M 3 H5
E 90T5-G H4 / E 90T5-GM H4

SK Vlastnosti a oblasť použitia:

Bázický rúrkový drôt, používaný pre zváranie vysoko pevných jemnozrnných oceľí. Minimálny rozstrek, dobrá odstrániteľnosť trosky, rovnomerný zvar.

GB Applications and properties:

Basic tubular cored electrode for welding of high-strength fine grain structural steels. Low spatter loss, easy slag removal, uniform bead appearance.

POL Zastosowania i własności:

Zasadowy drut rdzeniowy bez szwu do spawania wysokowytrzymałych drobnozrniastych stali konstrukcyjnych. Małe straty na rozprysk, łatwe usuwanie żużla, jednorodny wygląd lica spoiny.

Materials for instance:

EN-Designation	DIN-Designation	EN-Designation	DIN-Designation
S(P)460, S 620	StE 460, St E 620	–	HY 80

Approvals: TÜV, DB, BWB

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

C	Si	Mn	Ni	Mo
0,05	0,40	1,40	1,20	0,40

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	-60 °C
AW	≥ 560	650–750	≥20	>120	≥110	≥80	≥ 60	≥47
SR	≥ 540	630–710	≥20	>120	≥110	≥80	≥ 47	–

AW = as-welded

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

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

DIN EN 439 - C1 (100 Vol. % CO₂)

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:

