

PRODUCT DATA SHEET

Oerlikon Fluxofil 41



Fluxofil 41 is a seamless copper coated basic flux cored wire for the welding of high strength fine grain structural steels. Operating features include low spatter loss, easy slag removal and uniform bead appearance.

Storage

Keep dry and avoid condensation.

Classifications

AWS	A5.29	E90T5-G H4 / E90T5-GM H4
EN	12535	T 55 6 INiMo B C 3 H5

Approvals

BWB
DB

Typical Chemical Analysis (All weld metal)

% Carbon	0,05	% Nickel	1,2
% Manganese	1,4	% Molybdenum	1,4
% Silicon	1,4		

Typical Mechanical Properties (All weld metal)

Heat Treatment	As Welded	PWHT 580°C x 2 hr/furnace
Yield Strength N/mm ²	≥560	≥540
Tensile Strength N/mm ²	650 - 750	630 - 710
% Elongation on A5	≥20	≥20
Impact Energy at -20°C	≥80 J	≥47 J

Gas Test	CO ₂
Shielding Gas	CO ₂ or Afrox Fluxshield®
Materials	S(P)460-S(P)500, S550, HY 80

Packing Data

Diameter (mm)	Item Number
1,6	W125412

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