

MIG/MAG Cored Wires High-strength steels

FLUXOFIL 42 is a seamless copper coated basic flux cored wire for the welding of high-strength fine grain structural steels with minimum yield strength of 690 MPa. Operating features include low spatter loss, easy slag removal and uniform bead appearance.

Classification	
EN ISO	18276-A: T 69 6 Mn2NiCrMo B C 2 H5
EN ISO	18276-A: T 69 6 Mn2NiCrMo B M 2 H5
EN ISO	18276-B: T786T5-1 CA-N4C1M2-UH5
EN ISO	18276-B: T786T5-1 MA-N4C1M2-UH5
AWS	A5.29: E110T5-K4C-H4
AWS	A5.29: E110T5-K4M-H4

Approvals	Grade
ABS	3YQ690SA
ABS	4YQ690SA H5
BV	3Y69 MS H5
BV	4Y69 MS H5
DB	●
DNV	IIIV69MS H5
DNV	IVY69MS H5
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.06	1.5	0.3	0.01	0.01	0.4	2.3	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
				-20 °C	-40 °C	-60 °C
As Welded	≥ 690	780-890	≥ 17	≥ 80	≥ 80	≥ 60
580 °C x 2 h	≥ 670	760-840	≥ 17	≥ 60	≥ 47	

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

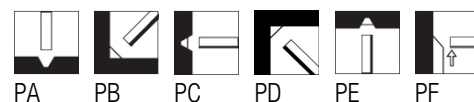
S620, S690, HY 100

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.2	●
1.6	●