

MIG/MAG Cored Wires High-strength steels

FLUXOFIL 42LT is a seamless copper coated basic flux cored wire alloyed with Cr-Ni-Mo. Used for applications requiring very high yield strength and impact toughness values at low temperatures. Suitable for steels such as S690. Suitable for welding in all positions. To be used with Ar/CO2 shielding gas.

Classification	
EN ISO	18276-A: T 69 6 Mn2NiCrMo B M 2 H5
EN ISO	18276-B: T86T5-1MA-N4C1M2-UH5
AWS	A5.29: E111T5-GM H4

Approvals	Grade
ABS	4Y69 SA H5
BV	4Y69 MS H5
DNV	IVY69 MS H5

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.08	1.6	0.4	≤ 0.015	≤ 0.015	0.3	2.4	0.45

All-weld metal Mechanical Properties







Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-50 °C
As Welded	≥ 690	760-900	≥ 15	≥ 47

Shielding Gas - EN ISO 14175 : M21

Materials

S620; S690; HY 100

Storage
Keep dry and avoid condensation

Current condition and welding position					
DC-					
 PA	 PB	 PC	 PD	 PE	 PF

Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16.0
1.2	●