

FLUXOFIL 45 is a seamless copper coated basic flux cored wire for welding high-strength fine grain structural steels. Quiet and smooth running with low spatter loss and easy slag removal producing uniform and smooth beads which are free from porosity. The mechanical properties of the weld depend on the cooling conditions and are influenced by the heat input and interpass temperature.

Classification	
EN ISO	18276-A: T 89 4 Z B M 2 H5
AWS	A5.29: E120T5-GM H4

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo
0.09	2	0.5	0.01	0.01	1	1.8	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-40 °C
As Welded	≥ 890	940-1180	≥ 15	≥ 47


Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : M21

Materials

S890

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
1.2	●