

## COREFIL 100M

Flux cored wires [FCAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 17632-A : T 42 2 M M 3 H5 AWS A-5.20 : E 70C-6M H4		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore

- Rutile flux cored wire with fast freezing slag.
- Designed for manual or automatic welding.
- For welding in all positions with CO<sub>2</sub> and M21 gas shielding.
- Very good and easy operated in all positions, excellent weld formation.
- Very good root pass on ceramic backing
- Possibility to perform welds in PF without waving the material.
- Works with a spray arc.
- Forced welding at low voltages (24-25 V) with a feed of 10-11 m and more.
- High purity of radiographic and ultrasonic tests.
- Low hydrogen content (H<5ml/100g).

### Base material



	EN
Construction steels:	S185, S235, S275, S355 e.t.c.
Shipbuilding steels:	Grade A, B, D, AH32-DH36 e.t.c.
Casts	GP240R e.t.c.
Pipes steels:	L210, L240, L290, L360 L240MB, L290MB, L360MB, L360QB, L240MB L290MB, L360MB, L415MB, L415NB X42, X46, X52, X60 P235T1, P235T2, P275T1 P275T2, P355N e.t.c.
Tanks and pressure steels	P235GH, P265GH, P295GH, P355GH
Finegrained steels:	S275, S355, S420 S275M, S275ML, S355M, S355ML, S420M, S420ML e.t.c.

### Typical chemical composition %

C	Si	Mn	P	S
0,05	0,75	1,60	< 0,02	< 0,02

### Typical mechanical properties

Yield strength Re [N/mm <sup>2</sup> ]	>420
Tensile strength Rm [N/mm <sup>2</sup> ]	500-640
Elongation A5 [%]	>25
Impact energy Kv [J]	>47 (-20°C), typical 120 J / >47 (-30°C), typical 100 J /

<b>Wire/rod type</b>	metal cored
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Shielding gases acc. to EN ISO 14175</b>	M20 - Ar + 10% CO2 / M21 - Ar + 15 - 25% CO2 /
<b>Remarks</b>	It is recommended to maintain a stick out of 20-25 mm between the tip and the base material.

#### Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	140-340	22-34	15-25	15,0

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