

## COREFIL 105M

Flux cored wires [FCAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 17632-A : T 46 4 M M21 1 H5 AWS A-5.20 : E 70C-6M H4		Power generation industry Constructions & Engineering Steel construction yards Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore

- High-Efficiency Metal-Cored Welding Wire
- Recommended for semi-automatic, fully automatic and robotic welding of non-alloyed and fine-grained structural steels.
- Perfect for down position welding and for the vertical positions as well
- Very high metal deposition efficiency and high welding speed.
- Stable spray arc droplet transfer with minimal spatter.
- Deep penetration, high resistance to porosity, and excellent wetting properties.
- Minimal slag formation allows for multi-pass welding without interpass cleaning.
- Very good weld metal appearance.

### Application

Konstrukcje stalowe, elementy maszyn, zbiorniki, fragmenty rur i kształtek spawane na obrotnikach w pozycjach podolnych.



### Base material

Stale konstrukcyjne	S185, S235, S275, S355 itp.
Stale okrętowe	Grade A, B, D, AH32-DH36 itp.
Odlewy	GP240R itp.
Stale na rury	L210, L240, L290, L360
	L240MB, L290MB, L360MB, L360QB, L240MB
	L290MB, L360MB, L415MB, L415NB
	X42, X46, X52, X60
	P235T1, P235T2, P275T1
	P275T2, P355N
	itp.
Zbiorniki i stale ciśnieniowe	P235GH, P265GH, P295GH, P355GH
Stale drobnoziarniste	S275, S355, S420
	S275M, S275ML, S355M, S355ML, S420M, S420ML
	itp.

### Typical chemical composition %

C	Si	Mn	P	S
0,05	0,65	1,50	<0,02	<0,02

**Typical mechanical properties**

<b>Yield strength Re [N/mm<sup>2</sup>]</b>	>460
<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	540-690
<b>Elongation A5 [%]</b>	>25
<b>Impact energy Kv [J]</b>	>47 J (-30°C) / >47 J (-40°C) /
<b>Wire/rod type</b>	proszkowy metaliczny
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Shielding gases acc. to EN ISO 14175</b>	M21 - Ar + 15 - 25% CO <sub>2</sub> / M20 - Ar + 10% CO <sub>2</sub> /
<b>Remarks</b>	Zaleca się utrzymanie wolnego wylotu (stick out) drutu na poziomie 20-25 mm pomiędzy końcówką a materiałem bazowym.

**Welding parameters and packing**

∅	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	150-340	24-36	15-25	15,0

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