

COREFIL 105R

Flux cored wires [FCAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 17632-A : T 46 3 PM(C)1 H5 AWS A-5.20 : E 71T-1M(C)/9M(C)	CE	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 CO₂ 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.
Pipe 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
< 0,06	< 0,60	1,50	< 0,02	< 0,02

Typical mechanical properties

Yield strength Re [N/mm²]	> 460
Tensile strength Rm [N/mm²]	530 - 680
Elongation A5 [%]	> 25

Impact energy Kv [J]	> 47 (-30°C), typical 130J /
Wire/rod type	rutile cored
Hydrogen content	< 5ml/100g
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	M21 - Ar + 15 - 25% CO2 / C1 - 100% CO2 /

Welding parameters and packing

Ø	Welding current [A]	Gas flow	Weight of packet [kg]
1,2	160-280	12-18	15,0

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