COREFIL 115R

Flux cored wires [FCAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 17632-A : T 46 4 P C 1 H5 AWS A-5.20 : E 71T-9C-J-H4	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 in a CO2 gas shielding.
- Very good and easy operating in all positions, excellent weld metal formation.
- Excellent for 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.
- Outstanding mechanical properties: 47 [J] at -40°C, typically 140 [J].
- Low hydrogen content (H<5ml/100g).

Base material

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
Fine-grained steels	S275, S355, S420
	S275M, S275ML, S355M, S355ML, S420M, S420ML
	e.t.c.

Typical chemical composition %

C	Si	Mn	Ni	P	S
0,05	0,40	1,30	0,40	< 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 (-40°C), typical 140J /
Wire/rod type	rutile cored

Hydrogen content	<5ml/100g
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 /

Welding parameters and packing

ø	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	160-320	22-34	12-18	15,0

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