COREFIL 113R

Flux cored wires [FCAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 17632-A : T 46 4 P M21 1 H5 AWS A-5.20 : E 71 T1M H4		Power generation industry Constructions & Engineering Steel construction yards Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore

- Micro-alloyed **seamless** rutile flux-cored wire with fast-freezing slag.
- For welding in all positions with CO2 and M21 gas shielding.
- Provides excellent weld bead formation and appearance.
- Performs exceptionally well in out-of-position welding, even at high amperages.
- Suitable for service temperatures up to -40°C.
- Perfect for orbital MAG welding and for welding with ceramic backing in all positions.
- Almost no spatters, with excellent and easy slag removal.
- Thanks to the seamless construction, the wir is resistant to atmospheric conditions, especially in installation and field conditions, maintaining a low H_2 content < 3ml/100g in weld metal.

Application

Steel structures, shipbuilding, tanks, machinery, and pipelines construction.

Base material

Construction steels:	S235, S275, S355, S420, S460
Shipbuilding steels:	Grade A, B, D, E, AH32-DH36, E36
Pipe steels:	L210, L240, L290, L360, L415, L450
	X42, X46, X52, X56, X60
	L240MB, L290MB, L360MB, L360QB
Finegrained steels:	S275N-S460N, S275M-S460M
Tanks and pressure steels:	P235T1, P235T2, P275T1, P355N, P275NL1 - P460NL1

Typical chemical composition %

C	Si	Mn	P	S
0,08	0,50	1,35	<0,015	<0,015

Typical mechanical properties

Yield strength Re [N/mm2]	>460
Tensile strength Rm [N/mm2]	530-680
Elongation A5 [%]	>22
Impact energy Kv [J]	>47J (-40°C) /
Wire/rod type	rutile
Hydrogen content	<5 ml/100g
Welding current	

Welding positions	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

⌀	**Weight of packet [kg]**
1,0	16,0
1,2	16,0
1,6	16,0

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