

# FLUXOFIL 20HD

## TOP FEATURES

- Seamless high deposition rutile flux cored wire with 1%Ni and impact toughness at -40°C.
- Excellent mechanical properties and diffusible Hydrogen content below 5 ml per 100g of deposited weld metal.
- All positional capability with outstanding performance in vertical up welding of fillet and butt welds.
- Ideal for applications in steel construction, offshore and shipbuilding segments.

## CLASSIFICATION

AWS A5.29	E81T1-Ni1M-JH4
EN ISO 17632-A	T 46 4 1Ni P M21 1 H5
EN ISO 17632-B	T554T1-1M21 A-N2-UH5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO<sub>2</sub>

## APPROVALS

ABS	LR	BV	DNV	RMRS	TÜV	DB
+	+	+	+	+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni
0.06	1.3	0.4	≤0.010	≤0.010	≤1.0

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	M21	AW	≥470	550-680	≥24	≥60
	M21	580°C x 2h/f.	≥470	550-680	≥24	≥47

\* AW = As welded

Gas test: 82% Ar + 18% CO<sub>2</sub>

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	W000281132
	SPOOL (B300)	16.0	W000281133
	SPOOL (B5300)	16.0	W000281333
1.6	SPOOL (B300)	16.0	W000281135
	SPOOL (B5300)	16.0	W000381135

#### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.