

FLUXOFIL 14HD

TOP FEATURES

- All positional capability with outstanding performance in vertical up welding of fillet and butt welds
- Coefficient of flux fill and current capacity designed to deliver all positional weldability
- Savings in welding cost resulting from easy slag removal and lack of spatters
- Ideal for applications in shipbuilding and steel construction
- Designed for mix gas, use of CO₂ is possible

CLASSIFICATION

AWS A5.20	E71T-1M-JH4
	E71T-1C-H4
EN ISO 17632-A	T 46 3 P M21 1 H5
	T 46 2 P C1 1 H5
EN ISO 17632-B	T 49 3 T1-1 M21 A-UH5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

APPROVALS

ABS, LR, BV, DNV, RINA, TÜV, DB, CWB

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO ₂
C1	Active gas 100% CO ₂
Flow rate	15-25 l/min

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

C	Mn	Si	P	S
0.05	1.4	0.5	≤0.010	≤0.010

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
						-20°C	-30°C	-40°C
Typical values	M21	AW	≥460	550-650	≥24	≥80	≥50	≥27

AW = As welded

Gas test: 82% Ar + 18% CO₂

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (S200)	5.0	W000281096
	SPOOL (B300)	16.0	W000281097
1.2	SPOOL (S200)	5.0	W000281098
	SPOOL (B300)	12.5	W000373239
	SPOOL (B300)	16.0	W000281099
	SPOOL (BS300)	16.0	W000381099
	DRUM	200.0	W000281100
1.6	SPOOL (B300)	16.0	W000281105
	SPOOL (BS300)	16.0	W000381105