

# FLUXOFIL 29HD

## TOP FEATURES

- Seamless high deposition rutile flux cored wire for welding of steels with Re 690 MPa.
- All positional capability with outstanding performance in positional welding of fillet and butt welds.
- Savings in welding cost resulting from easy slag removal and lack of spatters.

## CLASSIFICATION

AWS A5.29	E111T1-GM-H4
EN ISO 18276-A	T 69 4 Z P M21 1 H5
EN ISO 18276-B	T763T1-1M21 A-G-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

+

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

C	Mn	Si	P	S	Ni	Mo
0.06	1.4	0.4	≤0.010	≤0.010	2.9	0.35

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values		AW	≥690	770-895	≥17	≥47

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000278606

## 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.