

# Fluxofil 21HD

## TOP FEATURES

- 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

## TYPICAL APPLICATIONS

- Offshore

## CLASSIFICATION

AWS A5.29 E81T1-Ni1C-JH4  
EN ISO 17632-A T 46 4 1Ni P C1 1 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions, except vertical down

## APPROVALS

ABS, LR, BV, RINA, CE

## SHIELDING GASES (ACC. EN ISO 14175)

C1 Active gas 100% CO<sub>2</sub>  
Gas flow 15-25l/min

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

C	Mn	Si	P	S	Ni
0.07	1.4	0.4	≤0.010	≤0.010	0.9

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Typical values	C1	AW	≥490	570-670	≥22	≥70

AW = As welded

Gas test: 100% CO<sub>2</sub>

## AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000402449

## 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.