

FLUXOFIL 11HD

Cored Wires C-Mn and low-alloy steels

Fluxofil 11 HD is a seamless copper coated rutile flux cored wire. The higher filling degree of Fluxofil 11 HD results in a higher current carrying capacity and deposition rate. Welding speed is increased which leads to a saving of time and reduction of costs. It can be used in all positions with only one welding parameter setting (24 volts, wire feed = 9m/min, wire dia. 1,2 mm). Fluxofil 11 HD is used for manual welding, as well as in fully mechanized welding with the orbital welding unit Citotrack OSG-01 or the vertical welding set Citotrack VSG-01. It is preferably used under mixed shielding gas and is characterized by low spatter loss, good slag removal and finely rippled, pore-free welds without undercut into the base metal.

Classification

AWS	A5.20: E71T-1 H4 / E71T-1M H4
EN	758: T 46 2 P C 1 H5 / T 46 2 P M 1 H5

Approvals

Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.20	0.55	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
As Welded	≥ 460	550-650	≥ 22	≥ 80	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

S(P)235-S(P)460, GP240-GP280

Shipbuilding steels A,B,D,E,AH32 to EH36

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg. 16

Diameters	1,0	1,2	1,4	1,6		
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