

## Cored Wires C-Mn and low-alloy steels

Fluxofil 14 is a seamless copper coated rutile flux cored wire with a fast-freezing slag. Due to an easily controllable weld pool, it shows outstanding welding characteristics in all positions. It is particularly suitable for partly and fully mechanized welding of girth seams in pipelines. In MAG-orbital welding in the 6 to 12 o'clock position, 1,2-1,4 mm electrodes, are preferred. Low spatter loss, easy slag removal, smooth finely rippled welds without undercut into the base metal are outstanding features.

Classification	
AWS	A5.20: E71T-1MJ H4
EN	758: T 46 4 P M 1 H5

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
RS	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

### 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 <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
PWHT 580 °C x 2 h/furnace	≥ 460	550-650	≥ 22	≥ 60	-
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(Arcal 21-Atal 6)

### 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	2,0	2,4