

FLUXOFIL 14HDS

Cored Wires C-Mn and low-alloy steels

Fluxofil 14 HDS is a seamless copper coated rutile flux cored wire with an enhanced degree of fill. Due to an easily controllable weld pool, it features outstanding welding properties. Fluxofil 14 HDS can be welded in all positions with only one parameter setting. The enhanced degree of filling results in higher current carrying capacity and deposition rate, thus increased welding speeds may be used which leads to a saving of time and costs. Low spatter loss, easy slag removal, finely rippled and pore-free welds are produced without undercut.

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
ABS	
BV	
DB	
DNV	
GL	
LRS	
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	-	-	-	0.40	-	-	-	-	-

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	≥ 100	-

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	1,6		
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