

Cored Wires C-Mn and low-alloy steels

Fluxofil 19 HD is a seamless copper coated rutile flux cored wire with an enhanced degree of fill. Due to its easily controllable weld pool, the welding characteristics are outstanding. It can be welded in all positions with only one parameter setting (24 Volts, wire feed 9m/min, wire dia. 1,2 mm). The enhanced degree of filling results in increased current carrying capacity and deposition rate, thus increasing welding speed and leading to a saving of time and costs. Low spatter loss, easy slag removal, smooth and finely rippled welds are produced without undercut into the base metal.

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

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
PRS	
RINA	
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	0.50	-	-	-	-	-	-	-	-	-

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: C1(Arcal 2)

Shielding Gas: Acc. To EN 439: 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			