

# FLUXOFIL 19HDS

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

Fluxofil 19 HDS 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, using 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 producing smooth and finely rippled, pore-free welds 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       |        |
| RINA      |        |
| 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 | - | - | -  | 0.40 | -  | -  | - | - | -  |

### All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>A5 (%) | Impact Energy<br>ISO - V (J)<br>- 20 °C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|---|----------|
| As Welded      | ≥ 460                               | 550-650                               | ≥ 22                 | ≥ 100                                   | -        |

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 |  |  |  |
|-----------|-----|-----|-----|--|--|--|
|           |     |     |     |  |  |  |