

FLUXOFIL 21 HD

Cored Wires C-Mn and low-alloy steels

Fluxofil 21 HD is a seamless copper coated rutile flux cored wire and the enhanced degree of fill results in a higher current carrying capacity and deposition rate. Thus, welding speed may be increased which leads to a saving of time and costs. It can be welded in all positions using only one parameter setting (24 volts, wire feed 9 m/min, wire dia. 1,2 mm). Fluxofil 21 HD is also used for fully mechanized welding with the vertical welding unit Citotrack VSG-01. The weld metal produced features excellent mechanical-technological properties and a hydrogen content of < 5 ml per 100g deposited weld metal. Low spatter loss, easy slag removal producing finely rippled, pore-free welds without undercut into the base metal.

Classification	
AWS	A5.29: E81T1-Ni1 JH4
EN	758: T 46 4 1Ni P C 1 H5

Approvals	Grades
ABS	
LRS	

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	-	-	-	0.90	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
PWHT 580 °C x 2 h/furnace	≥ 490	570-670	≥ 22	≥ 47	-
As Welded	≥ 490	570-670	≥ 22	≥ 60	-

Gas test: Acc. To EN 439: C1(Arcal 2)

Shielding Gas: Acc. To EN 439: C1(Arcal 2)







Materials

S(P)275-S(P)460

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+					
					
PA	PB	PC	PG	PF	PE

Packaging data: K300 kg. 16

Diameters	1,0	1,2	1,6			