

# FLUXOFIL 18HD

## Cored Wires Weathering steels

Fluxofil 18 HD is a seamless copper coated special rutile cored wire, alloyed with Ni-Cr-Cu, used for the welding of weathering steels. To be used with CO<sub>2</sub> and Ar/CO<sub>2</sub> shielding gas mixture.

Classification	
AWS	A5.29: E80T5-G

Approvals	Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.04	1	0.40	≤ 0.020	≤ 0.020	0.55	0.50	0.01	-	-	-	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) -30°C	Hardness
As Welded	≥ 500	560-720	≥ 18	≥ 47	-

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

**Shielding Gas:** Acc. To EN 439: C1(Arcal 2) or M21(Arcal21-Atal6)

### Materials

S235J0W; S235J2W; S355J0W; S355J2W; S355K2W

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg. 16

Diameters	1,2					
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