FLUXOFIL 14 HD

OERLIKON

Cored Wires
C-Mn and low-alloy steels

FLUXOFIL 14 HD is a seamless copper coated rutile flux cored wire with an enhanced degree of fill for gas-shielded metal arc welding of unalloyed steels for operating temperatures from -30°C up to +450°C. 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. Preferably used under mixed gas. The use of CO2 is possible.

Classification	
EN ISO	17632-A: T 46 2 P C 1 H5
EN ISO	17632-A: T 46 3 P M 1 H5
EN ISO	17632-B: T552T1-1CA-UH5
EN ISO	17632-B: T553T1-1MA-UH5
AWS	A5.20: E71T-1C-H4
AWS	A5.20: E71T-1M-JH4

Approvals	Grade
ABS	3Y40SA H5
BV	SA3Y40M H5
DB	●
DNV	IIIY40MS H5
GL	3Y40H5S
LRS	3Y40S H5
PRS	3S-3Y40SH5
RMRS	3S-3Y40S H5
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05	1.4	0.5	≤ 0.010	≤ 0.010

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-20 °C	-30 °C
As Welded	≥ 460	550-650	≥ 24	≥ 80	≥ 50

Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : C1, M21

Materials

S(P)235-S(P)460

X42 - X65

Shipbuilding steels A,B,D,E,AH32 - EH36

Storage
Keep dry and avoid condensation

Current condition and welding position
DC+