

FLUXOFIL 14HD



Cored Wires
C-Mn and low-alloy steels

Fluxofil 14HD is a seamless copper coated rutile flux cored wire with a higher filling degree results in a higher current carrying capacity and high deposition rate. The welding speed is increased which leads to a saving of time and reduction of costs. It can be used in all positions with only one welding parameter setting (24 volts, wire feed = 9m/min, wire dia. 1.2 mm). Fluxofil 14 HD is used for manual welding, as well as in fully mechanized welding by means of an orbital welding unit. It is preferably used under mixed shielding gas and is characterized by low spatter loss, good slag removal and finely rippled, pore-free welds without undercut.

Classification	
AWS	A5.20: E71T-1 H4 / E71T-1M H4
EN	758: T 48 2 P C 1 H5 / T 48 2 P M 1 H5

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
PRS	
RS	
TÜV	
UDT	

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.20	0.55	-	-	-	-	-	-	-	-	-

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: M21

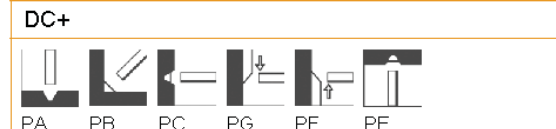
Shielding Gas: Acc. To EN 439: M21 or C1

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



Packaging data: K300 kg. 16

Diameters	1.2mm	1.6mm			

Diam.	16 kg Spool
1.2mm	OERFF14HD12

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com