

## FLUXOFIL 20 HD

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

Fluxofil 20 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 20 HD is also ideal 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 hydrogen < 5 ml per 100g deposited weld metal. Low spatter loss, easy slag removal producing finely rippled, pore-free welds without undercut.

Classification	
AWS	A5.29: E81T1-Ni1M JH4
EN	758: T 46 4 1Ni P M 1 H5

Approvals	Grades
ABS	
BV	
DB	
GL	
LRS	
RS	
TÜV	
UDT	

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 <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	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: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal 21-Atal 6)

### 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			
-----------	-----	-----	-----	--	--	--