

PRODUCT DATA SHEET

Oerlikon Fluxofil 14 HD



Fluxofil 14 HD is a seamless copper coated rutile flux cored wire with a higher filling degree resulting 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 V, wire feed = 9 m/min, wire dia. 1,2 mm). Fluxofil 14 HD is used for manual welding, as well as in fully mechanised. It is preferably used under mixed shielding

gas and is characterised by low spatter loss, good slag removal and finely rippled, pore-free welds without undercut.

Storage

Keep dry and avoid condensation.

Classifications

| | | |
|-----|---------|------------------------|
| AWS | A5.20 | E71T-I H4 / E71T-1M H4 |
| EN | I7632-A | T 46 2 P M I H5 |

Approvals

| | |
|-----------------------------|-----------------------------|
| American Bureau of Shipping | Lloyds Register of Shipping |
| Bureau Veritas | PRS |
| DB | RS |
| Det Norske Veritas | TÜV |
| Germanischer Lloyd | UDT |

Typical Chemical Analysis (All weld metal)

| | | | |
|-------------|------|-----------|------|
| % Carbon | 0,05 | % Silicon | 0,55 |
| % Manganese | 1,2 | | |

Typical Mechanical Properties (All weld metal)

| | |
|------------------------------------|-----------|
| Heat Treatment | As welded |
| Yield Strength N/mm ² | ≥460 |
| Tensile Strength N/mm ² | 550 - 650 |
| % Elongation on A5 | ≥22 |
| Impact Energy at -20°C | ≥80 J |

| | |
|---------------|--|
| Gas Test | Afrox Fluxshield® |
| Shielding Gas | Afrox Fluxshield® |
| Materials | S(P)235-S(P)460, GP240-GP280 Shipbuilding steels A,B,D,E,AH32 to EH36 |

Packing Data

| Diameter (mm) | Item Number |
|---------------|-------------|
| 1,2 | W125133 |
| 1,6 | W125134 |

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