

PRODUCT DATA SHEET

Oerlikon Fluxofil 19 HD



Fluxofil 19 HD is a seamless copper coated rutile flux cored wire with an enhanced degree of fill. 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 V, wire feed 9 m/min, wire diameter 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.

Storage

Keep dry and avoid condensation.

Classifications

AWS	A5.20	E71T-1 H4
EN	17632-A	T 46 2 P C I H5

Approvals

American Bureau of Shipping	Lloyds Register of Shipping
Bureau Veritas	PRS
DB	RINA
Det Norske Veritas	RS
Germanischer Lloyd	TÜV

Typical Chemical Analysis (All weld metal)

% Carbon	0,05	% Silicon	0,5
% Manganese	1,20		

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	CO ₂
Shielding Gas	CO ₂
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	W125150
1,6	W125152

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