

# PRODUCT DATA SHEET

## Oerlikon Fluxofil 20 HD



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 V, wire feed 9 m/min, wire diameter 1,2 mm). Fluxofil 20 HD is also ideal for fully mechanised welding.

The weld metal produced features excellent mechanical-technological properties and a hydrogen content of hydrogen

< 5 ml per 100 g deposited weld metal. Low spatter loss, easy slag removal producing finely rippled, pore-free welds without undercut.

### Storage

Keep dry and avoid condensation.

### Classifications

AWS	A5.29	E81T1-Ni1M JH4
EN	17632-A	T 46 4 INi P M I H5

### Approvals

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

### Typical Chemical Analysis (All weld metal)

% Carbon	0,05	% Silicon	0,5
% Manganese	1,2	% Nickel	0,9

### Typical Mechanical Properties (All weld metal)

Heat Treatment	As Welded	PWHT 580°C x 2 hr/furnace
Yield Strength N/mm <sup>2</sup>	≥490	≥490
Tensile Strength N/mm <sup>2</sup>	570 - 670	570 - 670
% Elongation on A5	≥22	≥22
Impact Energy at -20°C	≥60 J	≥47 J

Gas Test	Afrox Fluxshield®
Shielding Gas	Afrox Fluxshield®
Materials	S(P)275-S(P)460

### Packing Data

Diameter (mm)	Item Number
1,2	W125211
1,6	W125212

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