

MIG/MAG Cored Wires C-Mn and low-alloy steels

FLUXOFIL 14 is a seamless copper coated rutile flux cored wire with a fast-freezing slag. Due to an easily controllable weld pool, it shows outstanding welding characteristics in all positions. It is particularly suitable for partly and fully mechanized welding of girth seams in pipelines. In MAG-orbital welding in the 6 to 12 o'clock position, 1.2-1.4 mm electrodes, are preferred. Low spatter loss, easy slag removal, smooth finely rippled welds without undercut into the base metal are outstanding features.

Classification	
EN ISO	17632-A: T 46 4 P M 1 H5
EN ISO	17632-B: T554T1-1MA-UH5
AWS	A5.20: E71T-1M-JH4

Approvals	Grade
ABS	3YSA H5
BV	SA3YM H5
DNV	IIIY46MS H5
GL	3YH5S
LRS	3S-3YS H5
RMRS	3YS H10
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05	1.2	0.5	≤ 0.010	≤ 0.010

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-20 °C	-40 °C
As Welded	≥ 460	550-650	≥ 22	≥ 80	≥ 47

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : M21

Materials

Shipbuilding steels A,B,D,E,AH32 - EH36

S(P)235-S(P)460, GP240-GP280

Storage
Keep dry and avoid condensation

Current condition and welding position						
DC+						
						
PA	PB	PC	PD	PE	PF	PG

Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16
1.2	●