



# FLUXOFIL 14 HD

## SARME TUBULARE / FLUX CORED WIRE

### CLASIFICARE / STANDARDS

EN 758 : T 46 2 P M 1 H5  
 EN 758 : T 46 2 P C 1 H5  
 AWS A5.20 : E71T-1 MH4 / E71-1H4

### AUTORIZARI / APPROVALS

ABS : 3SA-3Y400SAH5 RINA : SG 52 3H5  
 DNV : III Y40MS(H5) LRS : 3SR1M21Y4643  
 CONTROLAS : T462PM1H5 ; TÜV : T462PC1H5-T462PM1H5  
 BV : 3-3Y 40 M H5  
 GL : 3Y 40 H5 5

### CARACTERISTICI PRINCIPALE

Sarma tubulara cuprata pentru sudarea intr-un singur strat sau in mai multe a structurilor metalice. Permite realizarea unor depuneri cu viteza mare de depunere, fara stropi, cu un arc stabil, cu un aspect al cordonului estetic chiar si pe table cu calamina. Recomandat in mod deosebit pentru utilizarea in constructii navale, in special in pozitia vertical descendenta, permitand realizarea unor cordoane de mici dimensiuni. Se poate suda folosind amestec de gaze Ar/CO<sub>2</sub> (M21 - EN 439) sau CO<sub>2</sub> de mare puritate. Este recomandat pentru sudarea otelurilor carbon de tipul Fe430 - Fe510, cu bune caracteristici de tenacitate pana la -20° C.

### MAIN FEATURES

Rutile seamless copper coated cored wire, for welding metal constructions in single or multipass technique. Designed for high deposition rate welding, stable and low spattering arc characteristics. Easy slag removal and good bead appearance, even on oxidized plates. Particularly designed for shipbuilding applications, especially for vertical up welding, even without waving the torch in order to obtain small size beads. Shielding gas: Mix Ar/CO<sub>2</sub> (M21 - EN 439) or CO<sub>2</sub>. For welding carbon manganese steels like Fe 430 - Fe 510, with good impact properties down to -20° C.

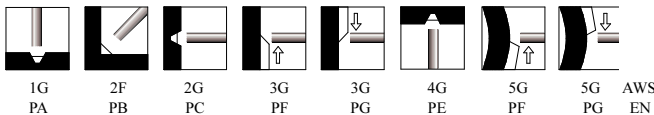
### DOMENII DE APLICATIE

Constructii navale  
 Constructii feroviare si de material rulant  
 Masini agricole  
 Constructii de poduri, masini de decopertat, etc.

### MAIN APPLICATIONS

Shipbuilding  
 Rolling stock construction  
 Agriculture machines  
 Bridge cranes, cranes, earth moving machines.

### POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC+  
 GAZ/GAS : Mix (Ar/CO<sub>2</sub>) or CO<sub>2</sub>  
 H<sub>2</sub> DIFF. / DIFF. H<sub>2</sub> : 3 ml / 100 g. max

### ANALIZA CHIMICA A METALULUI DEPUȘ % / ALL - WELD METAL CHEMICAL ANALYSIS %

GAZ/GAS	C	Mn	Si	S	P				
Mix	0.04 - 0.08	1.20 - 1.75	0.35 - 0.70	≤ 0.020	≤ 0.020				
CO <sub>2</sub>	0.03 - 0.07	1.00 - 1.50	0.20 - 0.60	≤ 0.020	≤ 0.020				

### CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ/GAS	Trat. termic/Heat treatment	Rm N/mm <sup>2</sup>	Rs N/mm <sup>2</sup>	E % 5d	Kv J -20°C	
Mix	Stare sudata/As welded	550 - 680	≥ 460	≥ 23	≥ 80	
CO <sub>2</sub>	Stare sudata/As welded	530 - 620	≥ 460	≥ 24	≥ 70	

### AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/Weigh t	Diametru mm/Diameter mm				
		1.0	1.2	1.4	1,6	
K 300	16 Kg	2636118	2636120	2636122	2636124	
C 5	5 Kg		2636130			

Datele mentionate pot fi modificate fara o notificare prealabila / The above data may change without prior notice.

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