



# PRODUCT DATA SHEET

## WCD 6702

# SEAMLESS FLUX CORED ARC WELDING WIRE

## FLUXOFIL 14H<sub>5</sub>



- ▶ Seamless, Tubular, Copper Coated, Flux Cored Wire
- ▶ Very Low Hydrogen "H<sub>5</sub>" Status
- ▶ Versatile, All Ppositional Fillet and Butt Welding Capabilities
- ▶ Formulated for use with Ar/CO<sub>2</sub> Shielding Gases
- ▶ Grade 3 Weld Metal Impact Properties

### Classifications

|            |                                   |
|------------|-----------------------------------|
| AS 2203.1  | ETP-GMp-W503A.CM1 H5 (superseded) |
| AS/NZS ISO | 17632 BT 49 2 T 11 M A U H5*      |
| AWS A5-20  | E71T-1M H5                        |

\*New classification replaces AS/NZS 2203.1

### Description & Applications

Fluxofil 14H<sub>5</sub> is a rutile based, tubular flux cored wire for all positional fillet and butt welding applications using Ar+15-25%CO<sub>2</sub> shielding gases. The unique Fluxofil process produces a seamless tube which prevents the ingress of moisture and allows the flux cored wire to be copper coated for enhanced wire feeding and improved current transfer from gun contact tip to wire.

Fluxofil 14H<sub>5</sub> produces an easly controlled, fast freezing slag which permits its use in all welding positions. Both 1.2mm and 1.6mm sizes are suitable for vertical up and overhead welding. The flux core of Fluxofil 14H<sub>5</sub> is micro-alloyed with Boron to produce enhanced CVN impact properties to -20°C and enhanced hydrogen controlled properties assisting in eliminating the risk of hydrogen assisted cold cracking.

Fluxifil 14H<sub>5</sub> is used for heavy construction and fabrication work where Grade 3 impact properties are required and components cannot be re-positioned for downhand welding. It is also recommended for semi or fully automatic seam or butt welding applications.

### Operational Data

| WIRE SIZE (mm) | WELDING CURRENT RANGE (AMPS) | ARC VOLTAGE RANGE (VOLTS) | TYPICAL STICKOUT (MM) |
|----------------|------------------------------|---------------------------|-----------------------|
| 1.2            | 140-280                      | 22-29                     | 19                    |
| 1.6            | 180-380                      | 23-30                     | 25                    |

Welding Current DC +

\* Voltage is determined by arc current and wire arc length. Welding currents and voltage shown are operational guides only.

### Shipping Approvals

LRS 3S, 3YS, H5

### Typical All Weld Metal Chemical Analysis

| C    | Mn  | Si   | B     | Fe  |
|------|-----|------|-------|-----|
| 0.05 | 1.2 | 0.55 | 0.004 | Bal |

### Typical All Weld Metal Mechanical Properties

|            |                          |
|------------|--------------------------|
| Gas Type   | Ar + 25% CO <sub>2</sub> |
| Yield      | 549 Mpa                  |
| Tensile    | 613 Mpa                  |
| Elongation | 25%                      |
| CVN        | 116J @ -20°C             |

In as welded condition.

### Packaging Data

| WIRE SIZE (mm) | PACKAGING SPOOL (kg) | PART NUMBER |
|----------------|----------------------|-------------|
| 1.2            | 15                   | 1412S       |
| 1.6            | 15                   | 1416S       |

### Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The intergrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.\*

Although Fluxofil 14H<sub>5</sub> is copper coated, the wire is not immune to deterioration. Wire should be stored in the plastic bag provided when not in use for extended periods. Recommended conditions of storage are a minimum temperature of 15°C and a maximum humidity of 60% RH.

\*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

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