STEELCORED 19 HD

TOP FEATURES

- Seamless high deposition rutile flux cored wire with an enhanced degree of fill for welding of unalloyed steels in CO_2 gas.
- All positional capability with outstanding performance in vertical up welding of fillet and butt welds.
- Coefficient of flux fill and current capacity designed to deliver all positional weldability.
- Savings in welding cost resulting from easy slag removal and lack of spatters.
- Ideal for applications in shibulding and steel construction.

CLASSIFICATION

AWS A5.20	E71T-1C-JH4
EN ISO 17632-A	T 46 3 P C 1 H5
EN ISO 17632-B	T553T1-1CA-UH5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO_2

APPROVALS

ABS	LR	BV	DNV	RINA	TÜV
+	+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.05	1.2	0.5	0.010	0.010

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-20°C	-30°C
Typical values	C1	AW	≥460	550-650	≥24	≥80	≥50

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (S200)	5.0	W000281669

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.