

STEELCORED 19 HD

MIG/MAG Cored Wires

C-Mn and low-alloy steels

STEELCORED 19 HD is a seamless copper coated rutile flux cored wire with an enhanced degree of fill. Due to its easily controllable weld pool, the welding characteristics are outstanding. It can be welded in all positions with only one parameter setting (24 Volts, wire feed 9m/min, wire dia. 1,2 mm). The enhanced degree of filling results in increased current carrying capacity and deposition rate, thus increasing welding speed and leading to a saving of time and costs. Low spatter loss, easy slag removal, smooth and finely rippled welds are produced without undercut into the base metal.



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

Approvals						
ABS	BV	DNV	GL	LRS	RINA	TÜV
3Y40SA H5	SA3Y40M H5	IIY40MS H5	3Y40H5S	3Y40S H5	3Y40S H5	●



Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
All weld metal	0.05	1.2	0.5	0.010	0.010

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-20 °C	-30 °C
As Welded	≥ 460	550-650	≥ 24	≥ 80	≥ 50

Gas test: 100% CO₂

Shielding Gas - EN ISO 14175 : M21

Materials








Shipbuilding steels A,B,D,E,AH32 to 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 Diam(mm) / weight(kg)	B200 5	B300 16	DRUM 200
1.0	●		
1.2	●	●	●
1.4		●	
1.6		●	

STEELCORED 21 HD

MIG/MAG Cored Wires

C-Mn and low-alloy steels

STEELCORED 21HD 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 volts, wire feed 9 m/min, wire dia. 1,2 mm). STEELCORED 21 HD is also used for fully mechanized welding. The weld metal produced features excellent mechanical-technological properties and a hydrogen content of < 5 ml/100g deposited weld metal. Low spatter loss, easy slag removal producing finely rippled, pore-free welds without undercut into the base metal.



Classification	
EN ISO	17632-A: T 46 4 1Ni P C 1 H5
EN ISO	17632-B: T554T1-1CA-N1-UH5
AWS	A5.29: E81T1-Ni1C-JH4

Approvals			
ABS	GL	LRS	RINA
4Y46SA H5	4Y46H5S	4Y46S H5	4Y46S H5

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S	Ni
All weld metal	0.05	1.2	0.5	0.010	0.010	0.9

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)
As Welded	≥ 490	570-670	≥ 22

Gas test: 100% CO₂

All-weld metal Mechanical Properties - CV

Heat Treatment	Impact Energy (J)
	-40 °C
As Welded	70

Shielding Gas - EN ISO 14175 : C1

Materials

S(P)275-S(P)460

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	B200	B300
Diam(mm) / weight(kg)	5	16
1.2	●	●