



HILCO HILCORD 40

Cored wires – unalloyed steel

AWS A5.20: E 71 T-1M

EN ISO 17632-A: T 42 2 P M 1 H10

Wire type:

Rutile cored wire

Current:



Welding positions:



Shielding gas:

M21

Hilcord 40 is our rutile flux cored wire for MAG welding unalloyed and low alloyed structural steels in all positions. This wire offers excellent weldability, good mechanical properties, practically no spatter and allows you to weld in spray arc mode. Hilcord 40 can be used in single and multipass applications, typical are: shipbuilding, machinery, bridge construction, rolling stock, and structural fabrication.

Base materials to be welded:

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-ESStE355, StE285TM-ESStE355TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0-St52.4, St45.8, X42-X60, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	S	P
0.06	1.30	0.45	≤ 0,030	≤ 0,030

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 400	≥ 480	≥ 22	-20°C ≥ 27

Packaging and welding data:

Dia. mm.	Spooltype	Weight / spool kg.	Current A	Voltage V
1.2	D300	15	150-300	22-32

Other sizes and spool types available on request