

## MIG/MAG Cored Wires Chromium-Molybdenum steels

FLUXOFIL 25 is a seamless copper coated rutile flux cored wire with a fast-freezing slag, suitable for the welding of creep resistant boiler and pipe steels, for operating temperatures up to 530 °C, as well as fine grain structural steels. Due to its easily controllable weld pool, it features outstanding welding properties in all positions. Low spatter loss, finely rippled welds without undercut.

Classification	
EN ISO	17634-A: T MoL P M 1 H5
EN ISO	17634-B: T55T1-1M-2M3-H5
AWS	A5.29: E81T1-A1M-H4

Approvals	Grade
TÜV	●
CE	

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Mo
0.05	1.1	0.4	0.01	0.01	0.5

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 490	550-650	≥ 22	≥ 50
580°C x 1h	≥ 470	550-620	≥ 23	≥ 70







Gas test: 82% Ar+18% CO2

**Shielding Gas** - EN ISO 14175 : M21

### Materials

S(P)235-S(P)460, 16Mo3

Storage
Keep dry and avoid condensation

Current condition and welding position					
DC+					
					
PA	PB	PC	PD	PE	PF

### Packaging data

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