

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 | Р | S | Мо |
|------|-----|-----|------|------|-----|
| 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

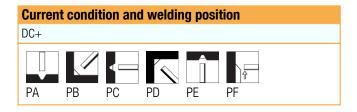
Shielding Gas - EN ISO 14175: M21

Materials

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

Storage

Keep dry and avoid condensation



Packaging data

| Packaging Type | B300 |
|-----------------------|------|
| Diam(mm) / weight(kg) | 16 |
| 1.2 | • |

