

MIG/MAG Cored Wires Chromium-Molybdenum steels

FLUXOFIL 36 is a seamless copper coated basic flux cored wire suitable for the welding of Cr Mo-alloyed boiler and pipe steels for high creep rupture strength up to 570 °C. Quiet and smooth fusion and low spatter loss with easy slag removal produce uniform and smooth weld beads which are free from porosity.

Classification	
EN ISO	17634-A: T CrMo1 B C 2 H5
EN ISO	17634-A: T CrMo1 B M 2 H5
EN ISO	17634-B: T55T5-1C-1CM-H5
EN ISO	17634-B: T55T5-1M-1CM-H5
AWS	A5.29: E80T5-B2C-H4
AWS	A5.29: E80T5-B2M-H4

Approvals	Grade
TÜV	●
CE	

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo
0.08	0.8	0.3	0.010	0.010	1.2	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
690 °C x 1h	≥ 470	550-660	≥ 22	≥ 120

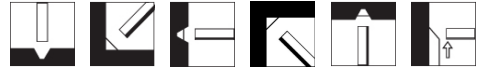
Gas test: 100% CO₂

Shielding Gas - EN ISO 14175 : C1, M21

Materials

13CrMo4-5, 13CrMoSi5-5; G17CrMo5-5

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	●
1.6	●