

## MIG/MAG Cored Wires Chromium-Molybdenum steels

FLUXOFIL 37 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 600 °C. Quiet and smooth running and low spatter loss with easy slag removal produce uniform and smooth beads which are free from porosity.

Classification	
EN ISO	17634-A: T CrMo2 B C 2 H5
EN ISO	17634-A: T CrMo2 B M 2 H5
EN ISO	17634-B: T55T5-1C-2C1M-H5
EN ISO	17634-B: T55T5-1M-2C1M-H5
AWS	A5.29: E80T5-B3C-H4
AWS	A5.29: E80T5-B3M-H4

Approvals	Grade
TÜV	●
CE	

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo
0.1	0.8	0.4	0.010	0.010	2.4	1.1

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
700°C x 1h	≥ 470	570-670	≥ 20	≥ 100

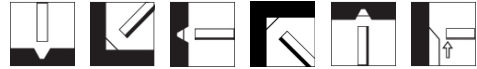
Gas test: 82% Ar+18% CO2

**Shielding Gas** - EN ISO 14175 : C1, M21

### Materials

10CrMo9-10, 12CrMo9-10; A387 Gr.22, Cl 1and 2, A 182 Gr.F 22, A 336 Gr.F22

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	●