

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	
AWS	A5.29: E 81T1-A1M H4
EN	12071: T MoL P M 1 H5

Approvals	Grades
TÜV	
UDT	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	1.20	0.40	-	-	-	-	0.50	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
PWHT 580 °C x 2 h	≥ 470	520-620	≥ 22	≥ 50	-
As Welded	≥ 490	550-650	≥ 20	≥ 70	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials


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

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB PC PG PF PE

Packaging data: K300 kg, 16

Diameters	1,2					
-----------	-----	--	--	--	--	--