

## Cored Wires Chromium-Molybdenum steels

Fluxofil 35 is a seamless copper coated basic flux cored wire 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. Quiet and stable arc with low spatter loss and easy slag removal produce a uniform and smooth weld bead surface which is free from porosity..

Classification	
AWS	A5.29: E80T5-G H 4 / E80T5-GM H 4
EN	12071: T MoL B C 3 H5 / T MoL B M 3 H5

Approvals	Grades
DB	
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	1.40	0.40	-	-	-	-	0.50	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
PWHT 580 °C x 2 h	≥ 470	520-620	≥ 22	≥ 40	-
As Welded	≥ 490	550-650	≥ 22	≥ 40	-

Gas test: Acc. To EN 439: C1(Arcal 2)

**Shielding Gas:** Acc. To EN 439: C1(Arcal 2) or M21(Arcal21-Atal6)


### Materials

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

**Storage**  
Keep dry and avoid condensation

**Current condition and welding position**

**DC+**



PA PB PC

**Packaging data:** K300 kg, 16

Diameters	1,2	1,6				
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