

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	
AWS	A5.29: E80T5-B2 H4 / E80T5-B2M H4
EN	12071: T CrMo 1 B C 3 H5
EN	12071: T CrMo 1 B M 3 H 5

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
0.06	1	0.40	-	-	1.20	-	0.45	-	-	-	-

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 920 °C x 0,5 h/air + 700 °C x 0,5 h	≥ 310	420-520	≥ 28	≥ 150	-
PWHT 700 °C x 2 h	≥ 470	560-660	≥ 20	≥ 120	-

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

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

Materials

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

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg, 16

Diameters	1,2	1,6				
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