

# FLUXOFIL 37

## 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	
AWS	A5.29: E80T5-G H 4 / E80T5-GM H 4
EN	12071: T CrMo 2 B C 3 H5
EN	12071: T CrMo 2 B M 3 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
0.06	0.80	0.35	-	-	2.30	-	1	-	-	-	-

### 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) + 20 °C	Hardness
PWHT 930 °C x 40 min. / 730 °C x 40 min.	≥ 370	500-600	≥ 22	≥ 130	-
PWHT 700 °C x 2 h	≥ 450	570-670	≥ 20	≥ 100	-

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

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

### 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+



**Packaging data:** K300 kg. 16

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