FLUXOFIL 38C

OERLIKON

Cored Wires
Chromium-Molybdenum steels

Fluxofil 38C is a seamless copper coated basic flux cored wire, suitable for the welding of Cr Mo V-alloyed 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 weld beads which are free from porosity.

Classification

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
0.10	0.80	0.25	-	-	1.30	0.40	1.10	-	0.25	-	-

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 950 °C x 0,5 h/air + 700 °C x 16 h	≥ 440	590-780	≥ 15	≥ 47	-
PWHT 950 °C x 0,5 h/air + 700 °C x 16 h	≥ 440	590-780	≥ 15	≥ 47	-
PWHT 700 °C x 6 h	≥ 500	650-780	≥ 15	≥ 47	-

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

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

Materials

G17CrMoV5-11

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+

PA PB PC

Packaging data: K300 kg. 16

Diameters	1,2					