

FLUXINOX 25.4-PF

Cored Wires Stainless and Heat resistant steels

Fluxinox 25.4-PF is an alloyed rutile cored wire with a fast-freezing slag for the joint welding of heat resistant Cr and Cr-Ni steels and cast steel. The weld metal is ferritic-austenitic. Due to its low nickel content, it can also be used for applications in sulphur-bearing, reducing or oxidizing conditions. It is non-scaling up to 1100 °C.

Fluxinox 25.4-PF exhibits excellent, almost spatter-free, welding properties. Very easy slag removal, finely rippled and shiny welds, free of undercut. The fast-freezing slag makes Fluxinox 25.4-PF well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
EN	12073:T Z 25 4 P M 1/ T Z 25 4 P C 1

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.10	0.60	0.90	-	-	25.50	4.50	-	-	-	-	-

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
As Welded	≥ 400	≥ 600	≥ 15	≥ 27	-

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

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

Materials

1.4724 (X 10 CrAl 13) - 1.4776 (G-X 40 CrSi 29) - 1.4742 (X 10 CrAl 18)

1.4762 (X 10 CrAl 24) - 1.4823 (G-X CrNiSi 27 4)

1.4821 (X 20 CrNiSi 25 4) - 1.4745 (G-X 40 CrSi 29) - 1.4822 (G-X 40 CrNi 24 5)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+				
				
PA	PB	PC	PF	PE

Packaging data: K300 kg. 16

Diameters	1,2				
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