

PRODUCT DATA SHEET

Oerlikon Fluxofil 35



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.

Storage

Keep dry and avoid condensation.

Classifications

AWS	A5.29	E80T5-G H 4 / E80T5-GM H 4
EN	17634-A	T MoL B C 3 H5 / T MoL B M 3 H5

Approvals

DB
TÜV
UDT

Typical Chemical Analysis (All weld metal)

% Carbon	0,05	% Silicon	0,4
% Manganese	1,4	% Molybdenum	0,5

Typical Mechanical Properties (All weld metal)

Heat Treatment	As Welded	PWHT 580°C x 2 hr/furnace
Yield Strength N/mm ²	≥490	≥470
Tensile Strength N/mm ²	550 - 650	520 - 620
% Elongation on A5	≥22	≥22
Impact Energy at -20°C	≥40 J	≥40 J

Gas Test	CO ₂ or Afrox Fluxshield®
Shielding Gas	CO ₂ or Afrox Fluxshield®
Materials	S(P)235-S(P)460, 16Mo3

Packing Data

Diameter (mm)	Item Number
1,2	W125351
1,6	W125352

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