

# FLUXOFIL 25

## TOP FEATURES

- All positional 0.5% Mo seamless copper coated rutile flux cored wire with a fast-freezing slag.
- Exceptional productivity in positional welding.

## TYPICAL APPLICATIONS

- Power Generation

## CLASSIFICATION

AWS A5.29 E81T1-A1M-H4  
EN ISO 17634-A T MoL P M21 1 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All position, except vertical down

## SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ >15-25% CO<sub>2</sub>

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Mo
0.05	1.1	0.4	0.01	0.01	0.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 20°C
Typical values	M21	AW	≥490	550-650	≥22	≥70
	M21	620°C x 1h	≥470	550-690	≥22	≥70

\* AW = As welded

Gas test: 82% Ar + 18% CO<sub>2</sub>

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (B300)	16.0	W000281233

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.