

# FLUXOCORD 31



## SAW Cored Wires C-Mn and low-alloy steels

Fluxocord 31 is a seamless copper coated basic flux cored wire for submerged arc welding. Used for the welding of structural and fine grain steels in combination with the following fluxes: OP 121TT (DC+ or AC) and OP 41TT (only DC+).

Flux	Classification
OP 121TT	AWS A5.17: F7AP4-EC-G

Flux	Approvals	Grades
	ABS	
	BV	
	DB	
	DNV	
	GL	

see Appendix, Classification Society Approvals, for details pag. 521

### Typical Applications

Flux	Materials
OP 121TT	ASME: A516 all grades EN: S(P)235 - S(P)420

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 121TT	0.05	1.60	0.20	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Flux	Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)
OP 121TT	PWHT 580°C x 2h	≥ 440	520 - 620	≥ 25
OP 121TT	As Welded	≥ 460	520 - 650	≥ 25

### All-weld metal Mechanical Properties - Cv

Flux	Heat Treatment	Charpy V Notch Impact Toughness (J)							
		+20	0	-20	-30	-40	-50	-60	-196
OP 121TT	As Welded	-	-	140	-	100	-	-	-
OP 121TT	PWHT	-	-	140	-	100	-	-	-

### Current condition

DC+; AC

**Packaging data:** K415 kg, 25

Diameters	2,4	3,2	4,0	5,0