

# FLUXOCORD 43.1

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

Fluxocord 43.1 is a seamless copper coated basic flux cored wire for submerged arc welding. Used in combination with OP 121TT and OP 41TT in construction of pressure vessel and pipe-work. Weldments should be normalised or normalised and tempered following welding and the heat treatment will depend on both the composition of the weldment and the mechanical properties required. The weld metal deposited by Fluxocord 43.1 is not designed for use in either the as welded or stress relieved conditions.

Flux	Classification	Flux	Approvals	Grades
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### Typical Applications

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 121TT	0.05	1.40	0.10	-	1.80	0.35	-	-	-

### 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	N+A (A=550-650°C)	≥ 460	570 - 670	≥ 22
OP 121TT	N =940°C (t. depend on plate thick.)	≥ 420	550 - 650	≥ 22

### 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	N	-	-	100	-	80	-	47	-
OP 121TT	N+A	-	-	100	-	80	-	47	-

### Current condition

DC+; AC

**Packaging data:** K415 kg. 25

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