

SAW Cored Wires C-Mn and low-alloy steels

Fluxocord 48HD is a seamless copper coated basic flux cored wire for submerged arc welding. The deposition rate is increased by ~30% compared to a solid wire of equivalent diameter. Fluxocord 48HD is a highly cost effective route to high productivity welding. Used for the welding of weathering and higher strength steels, in combination with OP 121TT flux for tough joints in thicker sections and with OP 139 for high speed fillet welding.

Flux	Classification
OP 139	AWS A5.23: F8A2-ECG-G
OP 121TT	AWS A5.23: F8A3-ECG-G
OP 139	EN 756: S 46 3 AB TZ
OP 121TT	EN 756: S 46 4 FB TZ

Flux	Approvals	Grades
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Typical Applications

Flux	Materials
OP 121TT	ASME: SA 572-50; A 588; A 606-4; A 262 EN: S235J0W; S235J2W; S355J0W; S355J2W; S355K2W; CORTEN A-B-C
OP 139	ASME: SA 572-50; A 588; A 606-4; A 262 EN: S235J0W; S235J2W; S355J0W; S355J2W; S355K2W; CORTEN A-B-C

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 139	0.06	1.40	0.60	0.40	0.60	-	-	-	0.50
OP 121TT	0.05	1.30	0.20	0.40	0.70	-	-	-	0.60

All-weld metal Mechanical Properties

Flux	Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)
OP 139	As Welded	≥ 460	540 - 620	≥ 20
OP 121TT	As Welded	≥ 460	540 - 620	≥ 20

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	-	-	100	80	60	-	-	-
OP 139	As Welded	-	100	80	60	-	-	-	-

Current condition

DC+; AC

Packaging data: K415 kg, 25

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