

SAW Cored Wires C-Mn and low-alloy steels

Fluxocord 41HD 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 41HD is a highly cost effective route to high productivity welding. Used for the welding of high strength steels in combination with OP 121TT W flux.

Flux	Classification	
OP 121TT W	AWS	A5.23: F9A8-EC-F3
OP 121TT W	AWS	A5.23: F8P8-EC-F3
OP 121TT W	EN	756: S 50 6 FB T2Ni1Mo

Flux	Approvals	Grades
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Typical Applications

Flux	Materials
OP 121TT W	ASME: X70; X80; N-A-XTRA 55; HY80; QIN; SA 302 Gr.C-D EN: S(P)420; S(P)500; L245-L485; 20MnMoNi5-5; 15NiCuMoNb5

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 121TT W	0.05	1.30	0.20	-	0.90	0.50	-	-	-

All-weld metal Mechanical Properties

Flux	Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)
OP 121TT W	PWHT 610°C x 8h	≥ 470	550 - 700	≥ 20
OP 121TT W	As Welded	≥ 550	620 - 720	≥ 18

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 W	As Welded	-	-	200	-	110	-	60	-
OP 121TT W	PWHT	-	-	200	-	100	-	60	-

Current condition

DC+; AC

Packaging data: K415 kg, 25

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