

FLUXOCORD 42

SAW Cored Wires C-Mn and low-alloy steels

Fluxocord 42 is a seamless copper coated basic flux cored wire for submerged arc welding. Used for the welding of high strength steels in combination with fluxes OP 121TT W and OP 41TT. The weld metal composition obtained with Fluxocord 42 meets the mechanical property requirements in both the as welded and stress relieved conditions. Before use, welding flux should be re-dried at 300-350°C.

Flux	Classification
OP 121TT W	AWS A5.23: F11A4-EC-F5

Flux	Approvals	Grades
	DB	
	DNV	
	GL	

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

Typical Applications

Flux	Materials
OP 121TT W	ASME: X80; HY80; QIN; SA 302 Gr.C-D EN: S620-S690

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 121TT W	0.05	1.40	0.20	0.60	2.50	0.40	-	-	-

All-weld metal Mechanical Properties

Flux	Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)
OP 121TT W	PWHT 580°C x 2h	≥ 660	740 - 820	≥ 16
OP 121TT W	As Welded	≥ 680	750 - 830	≥ 16

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	-	-	80	-	50	-	-	-
OP 121TT W	PWHT	-	-	50	-	100	-	-	-

Current condition

DC+; AC

Packaging data: K415 kg. 25

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