

FLUXOCORD 40C is a seamless copper coated basic flux cored wire for submerged arc welding on fine-grain structural steels. Weld metal with OERLIKON flux OP 121TT has a special composition with 0,1%C - 1,3%Mn - 0,9%Ni, resulting in excellent mechanical properties in as welded, stress relieved and normalised condition as well. FLUXOCORD 40C is used in combination with OP 121TT.

Classification	
OP 121TT	AWS A5.23: F7AP8-EC-Ni1

Chemical analysis (Typical values in %)

		C	Mn	Si	Ni
All weld metal	OP 121TT	0.1	1.3	0.2	0.9

All-weld metal Mechanical Properties

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
OP 121TT	As Welded	≥ 480	550-680	≥ 22
OP 121TT	620°Cx1h	≥ 460	530-660	≥ 24

All-weld metal Mechanical Properties - CV

	Heat Treatment	Impact Energy (J)	
		-40 °C	-60 °C
OP 121TT	As Welded	≥ 80	≥ 47
OP 121TT	620°Cx1h	≥ 100	≥ 47

Typical applications

	Materials
OP 121TT	EN: SP275NL2 - S/P460NL2

Current Conditions

AC; DC+

Packaging data

Packaging Type	B450
Diam(mm) / weight(kg)	25
2.4	●
3.2	●
4.0	●