

# FLUXOCORD 40

## TOP FEATURES

- Seamless copper coated flux cored wire
- Nickel content to ensure high impact toughness down to -60°C
- Also compatible with applications requiring a post weld heat treatment

## CLASSIFICATION

Flux	AWS 5.23
OP 121TT	F7A8-EC-G

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	C	Mn	Si	Ni
OP 121TT	0.05	1.3	0.2	1.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Flux	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-20°C	-40°C	-60°C
OP 121TT	AW	≥ 450	540-620	≥24	≥140	≥100	
OP 121TT	PWHT 580°C/2h	≥ 440	520-600	≥24	≥140	≥100	≥60

\*AW = As welded; PWHT = Post weld heat treatment

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
4.0	SPOOL	25.0	W000379143

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.