FLUXOCORD 31

TOP FEATURES

- Seamless copper coated flux cored wire
- Weld metal composition similar to what obtained with an EH12K solid wire grade
- Impact toughness down to -40°C in both As welded and PWHT conditions

CLASSIFICATION

Flux	AWS 5.17
OP 121TT	F7A4/F7P4-EC-1

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	C	Mn	Si
OP 121TT	0.05	1.6	0.2

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Flux	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-20°C	-40°C
OP 121TT	AW	≥ 460	520-650	≥25	140	100
OP 121TT	PWHT 580°C/2h	≥ 440	520-620	≥25	140	100

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

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
3.2	SPOOL	25.0	W000282008
4.0	SPOOL	25.0	W000282012

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 for any updated information.