

# FLUXOCORD 42

## TOP FEATURES

- Seamless copper coated fluxcored wire
- Maintain high yield strength above 690MPa in both as welded and after stress relieved conditions
- Low diffusible hydrogen in combination with OP121TTW

## CLASSIFICATION

Flux	AWS 5.23	EN ISO 26304-A
OP 121TTW	F11A8/F11P5-EC-F5	S 69 6 FB (T3Ni2,5CrMo) H5

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

	C	Mn	Si	Cr	Ni	Mo
OP 121TTW	0.07	1.4	0.25	0.5	2.5	0.4

## 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 121TTW	AW	≥ 690	760-900	≥ 16	≥ 90	≥ 80	≥ 69
OP 121TTW	PWHT 620°C/1h	≥ 690	740-880	≥ 16	≥ 69	≥ 47	

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

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.6	SPOOL	16.0	W000282112
2.0	SPOOL	25.0	W000282115
2.4	SPOOL	25.0	W000282117
3.2	SPOOL	25.0	W000282119
4.0	SPOOL	25.0	W000380453
	SPOOL	80.0	W000386904
	SPOOL	90.0	W000380434

## 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.