

FLUXOCORD 44 TN

TOP FEATURES

- Seamless copper coated flux cored wire
- Designed for 3,5%Ni steels that are sensitive to decarburization of the heat affected zone by the post weld heat treatment
- Excellent impact toughness down to -90°C after post weld heat treatment
- Recommended in DC+ only

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	C	Mn	Si	Ni	Mo
OP 121TTW	0.05	0.8	0.3	3	0.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Flux	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-40°C	-75°C	-90°C
OP 121TTW	PWHT 595°C/4h	> 485	> 520	≥20	≥155	≥70	≥27

*PWHT = Post Weld Heat Treatment

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.4	SPOOL	25.0	W000282075

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.