

FLUXOCORD 40C

TOP FEATURES

- Low alloy seamless copper coated flux cored wire
- Limited drop of yield properties after PWHT
- Compatible with NACE requirements. Nickel content below 1%

CLASSIFICATION

Flux	AWS 5.23
OP 121TT	F7A8/F7P8-EC-Ni1

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	C	Mn	Si	Ni
OP 121TT	0.1	1.3	0.2	0.9

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Flux	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-40°C	-60°C
OP 121TT	AW	≥ 480	550-680	≥22	≥80	≥ 47
OP 121TT	PWHT 620°C/1h	≥ 460	530-660	≥24	≥100	≥ 47

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

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.4	SPOOL	25.0	W000377272
4.0	SPOOL	25.0	W000379137

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.