

FLUXOCORD 31HD is a seamless copper coated basic flux cored wire for submerged arc welding of fine grain structural steels. The deposition rate is increased by ~30% compared to a solid wire of equivalent diameter at the same current, however higher currents can be applied due to its superior welding properties. Single wire 4 mm welded at 900 amps will give deposit rate ~ 15 kg per hour, and in tandem 25 - 30 kg/hour. Thus, FLUXOCORD 31HD clearly contributes to increasing the productivity. Fluxocord 31HD is used with OP121TTW; in this combination, the diffusible hydrogen (HD) will be below 5 ml / 100g

Classification	
OP 121TTW	EN ISO 14171-A- S 46 5 FB TZ
OP 121TTW	AWS A5.17: F8A8-ECG

Approvals	Grade	
OP 121TTW	ABS	4Y420M H5
OP 121TTW	DNV-GL	4Y42M H5
OP 121TTW	LRS	4Y42M H5
OP 121TTW	RINA	4Y42 H5
OP 121TTW	TÜV	●

## Chemical analysis (Typical values in %)

		C	Mn	Si
All weld metal	OP 121TTW	0.06	2.0	0.6

## All-weld metal Mechanical Properties

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
					-46 °C	-50 °C	-60 °C
OP 121TTW	As Welded	≥ 460	550-680	≥ 25	≥ 100	≥ 47	≥ 27
OP 121TTW	620°Cx1h	≥ 400	485-640	≥ 25	≥ 100		≥ 47
OP 121TTW	620°Cx12h	≥ 315	440-600	≥ 25	≥ 80		

## Typical applications

Materials	
OP 121TTW	EN: S(P)235 - S(P)460; ASME: A516 (all Grades)

### Storage

keep dry and avoid condensation

### Current Conditions

AC; DC+

## Packaging data

Packaging Type	B450	B450XSEA	B570	DRUMXCL	S760
Diam(mm) / weight(kg)	25	25	90	250	300
3.2	W000282024				
4.0	W000282028	●	●	●	●