

FLUXOCORD 41 is a seamless copper coated basic flux cored wire for submerged arc welding on higher-strength fine-grain structural steels. FLUXOCORD 41 is used in combination with OP 121TT.

Classification		
OP 121TT	EN ISO	26304-A: S 55 6 FB TZ
OP 121TT	AWS	A5.23: F8P6-EC-G
OP 121TT	AWS	A5.23: F9A8-EC-G

Approvals	Grade
OP 121TT	TÜV ●

Chemical analysis (Typical values in %)

		C	Mn	Si	Ni	Mo
All weld metal	OP 121TT	0.05	1.5	0.3	1.5	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥ 550	640-760	≥ 20
620°Cx1h	≥ 500	600-710	≥ 22

All-weld metal Mechanical Properties - CV

Heat Treatment	Impact Energy (J)		
	-20 °C	-40 °C	-60 °C
As Welded	≥ 100	≥ 60	>47
620°Cx1h	≥ 120	≥ 100	≥ 60

Typical applications

	Materials
OP 121TT	ASME: API-5L: X70; X80; N-A-XTRA 55; HY80; QIN; SA302 Gr.C-D EN: S(P)420; S(P)500; L245-L485; 20MnMoNi5-5; 15NiCuMoNb5

Current Conditions

AC; DC+

Packaging data

Packaging Type	B450
Diam(mm) / weight(kg)	25
3.2	●
4.0	●