

SAW Cored Wires C-Mn and low-alloy steels

FLUXOCORD 31 is a seamless copper coated basic flux cored wire for submerged arc welding of unalloyed steels and fine grain structural steels in combination with the OERLIKON flux OP 121TT (DC+ or AC)

Classification	
OP 121TT	AWS A5.17: F7AP4-EC-G

Approvals	Grade
OP 121TT ABS	3M
OP 121TT DB	●

Chemical analysis (Typical values in %)

		C	Mn	Si
All weld metal	OP 121TT	0.05	1.6	0.2

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥ 460	520-650	≥ 25
580°Cx2h	≥ 440	520-620	≥ 25

All-weld metal Mechanical Properties - CV

Heat Treatment	Impact Energy (J)	
	-20 °C	-40 °C
As Welded	140	100
580°Cx2h	140	100

Typical applications

	Materials
OP 121TT	ASME: A516 (all Grades) EN: S(P)235 - S(P)420

Current Conditions

AC; DC+

Packaging data

Packaging Type	B450
Diam(mm) / weight(kg)	25
2.4	●
3.2	●
4.0	●