

FLUXOCORD 43.1 is a seamless copper coated basic flux cored wire for submerged arc welding with OERLIKON welding flux OP 121TT (DC+ or AC) (or evt OP 121TTW) for applications in boiler, apparatus and pipe-line construction when the weldments have to be normalised after welding. The requirements concerning the mechanical and technological properties of the welding joint are fulfilled in the normalised condition as well as in the air hardened condition. The necessary heat treatment depends on the base material. The weld metal deposited by FLUXOCORD 43.1 has not been designed for use in either the as welded nor stress relieved condition.

### Chemical analysis (Typical values in %)

		C	Mn	Si	Ni	Mo	V
All weld metal	OP 121TT	0.05	1.4	0.1	1.9	0.35	0.1

### All-weld metal Mechanical Properties

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
OP 121TT	600°C	≥ 460	570-670	≥ 22
OP 121TT	940°C+600°C	≥ 420	550-650	≥ 22

### All-weld metal Mechanical Properties - CV

	Heat Treatment	Impact Energy (J)		
		-20 °C	-40 °C	-60 °C
OP 121TT	600°C	100	80	47
OP 121TT	940°C+600°C	100	80	47

### Materials

EN: S(P)420; S(P)460; S500

#### Current Conditions

AC; DC+

### Packaging data

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