

FLUXOCORD 48HD is a seamless copper coated basic flux cored wire for submerged arc welding on weathering steels. The deposition rate is increased by ~30% compared to a solid wire of equivalent diameter. Thus, FLUXOCORD 48HD clearly contributes to increasing the productivity. For thicker sections FLUXOCORD 48HD is used in combination with OP 121TT. For fillet welds and applications requiring a maximum welding speed, optimum results are obtained in combination with OP 192.

| Classification |        |                       |
|----------------|--------|-----------------------|
| OP 192         | EN ISO | 14171-A- S 46 3 AB TZ |
| OP 121TT       | EN ISO | 14171-A- S 46 4 FB TZ |
| OP 192         | AWS    | A5.23: F8A2-EC-G      |
| OP 121TT       | AWS    | A5.23: F8A2-EC-G      |

## Chemical analysis (Typical values in %)

|                |          | C    | Mn  | Si  | Cr  | Ni  | Cu  |
|----------------|----------|------|-----|-----|-----|-----|-----|
| All weld metal | OP 192   | 0.06 | 1.4 | 0.6 | 0.4 | 0.6 | 0.5 |
| All weld metal | OP 121TT | 0.05 | 1.3 | 0.2 | 0.4 | 0.7 | 0.6 |

## All-weld metal Mechanical Properties

|          | Heat Treatment | Yield Strength (MPa) | Tensile Strength (MPa) | Elongation A5 (%) |
|----------|----------------|----------------------|------------------------|-------------------|
| OP 192   | As Welded      | ≥ 460                | 540 - 620              | ≥ 20              |
| OP 121TT | As Welded      | ≥ 460                | 540 - 620              | ≥ 20              |

## All-weld metal Mechanical Properties - CV

|          | Heat Treatment | Impact Energy (J) |        |        |        |
|----------|----------------|-------------------|--------|--------|--------|
|          |                | 0 °C              | -20 °C | -30 °C | -40 °C |
| OP 192   | As Welded      | 100               | 80     | 60     |        |
| OP 121TT | As Welded      |                   | 100    | 80     | 60     |

## Typical applications

|          | Materials                                                                                           |
|----------|-----------------------------------------------------------------------------------------------------|
| OP 192   | EN: S235J0W; S235J2W; S355J0W; S355J2W; S355K2W; CORTEN A-B-C ; ASME: SA 572-50; A588; A606-4; A262 |
| OP 121TT | EN: S235J0W; S235J2W; S355J0W; S355J2W; S355K2W; CORTEN A-B-C ; ASME: SA572-50; A588; A606-4; A262  |

### Storage

Keep dry and avoid condensation

### Current Conditions

AC; DC+

## Packaging data

| Packaging Type        | B450       |
|-----------------------|------------|
| Diam(mm) / weight(kg) | 25         |
| 2.4                   | W000282089 |
| 3.2                   | W000282091 |
| 4.0                   | W000282095 |