

# OP 120 TT

## TOP FEATURES

- For multipass welding applications
- Excellent toughness with OE-S2 wires
- Good slag release in narrow grooves
- Slightly contributes to the Manganese and Silicon content in the weld

## CLASSIFICATION

Flux	EN ISO 14174: SA FB 1 66 AC H5	
Flux/wire	AWS 5.17	AWS 5.23
OE-S2	F7A8/F7P8-EM12K- H4	
OE-S2Mo		F8A4-EA2-A2
OE-SD2 1NiCrMo		F10P4-EG-G

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	Cr	Ni	Mo
OE-S2	0.06	1.2	0.4	-	-	-
OE-S2Mo	0.06	1.2	0.4	-	-	0.5
OE-SD3 1Ni $\frac{1}{2}$ Mo	0.05	1.6	0.4	-	0.9	0.5
OE-S2 CrMo1	0.07	1.2	0.3	1.0	-	0.5
OE-SD2 1NiCrMo	0.06	1.4	0.5	1.0	0.9	0.6

- = not specified

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)				
					+20°C	0°C	-20°C	-40°C	-60°C
OE-S2	AW	≥ 420	500-600	≥24	-	≥130	≥100	≥70	≥50
OE-S2Mo	AW	≥450	600-700	≥24	-	≥90	≥70	≥40	-
OE-SD3 1Ni $\frac{1}{2}$ Mo	PWHT 620°C/1h	≥580	680-800	≥30	-	-	-	≥40	-
OE-S2 CrMo1	PWHT 680°C/2h	≥380	570-670	≥22	≥200	≥150	-	-	-
OE-S2 CrMo1	PWHT 920°C/air+720°C	≥310	430-530	≥28	-	≥200	-	-	-
OE-SD2 1NiCrMo	AW	≥760	840-870	≥24	-	-	-	≥40	-
OE-SD2 1NiCrMo	PWHT 660°C/3h	≥590	690-720	≥26	-	-	-	≥27	-

\* AW = As welded, PWHT = Post Weld Heat Treatment

- = not specified

## FLUX CHARACTERISTICS

Current type	AC, DC+
Basicity (Boniszewski)	3.1
Redrying	300-350°C x min. 2h

## AVAILABLE SIZES AND PACKAGING INFORMATION

Packaging	Weight (kg)	Item number
DRY BAG	25.0	W000386313

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
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