OP 132

TOP FEATURES

- A nitrogen limiting flux designed for seam welding of pipes.
- Recommended for automatic single pass/2-run welding with up to five arcs.
- Very high current carrying capacity

CLASSIFICATION

Flux	EN ISO 14174: SA AB 1 67 AC H5

Flux/wire	AWS A5.17	AWS A5.23
OE-S2	F7A5-EM12K	
OE-S2		F6TA2G-EM12K
OE-SD3	F7A5-EH12K	
OE-S2Mo		F8A5/F7P5-EA2-G
OE-S2Mo		F7TA4G-EA2
OE-SD3 1Ni 1/4Mo		F8A6/F8P5-ENi5-G
OE-SD3 1Ni 1/4Mo		F8TA4G-ENi5
OE-SD3 1Ni 1/2Mo		F8TA4G-EF3
OE-SD3 1Ni 1/2Mo		F9A6/F9P5-EF3-F3
OE-TIBOR 25		F8TA5G-EG
OE-TIBOR 33		F9A4-EA2TiB-G
OE-TIBOR 33		F9TA6G-EA2TiB

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

Wire grade	C	Mn	Si	Ni	Mo
OE-S2	0.07	1.3	0.2		
OE-SD3	0.07	1.8	0.4		
OE-S2Mo	0.07	1.3	0.2		0.5
OE-SD3 1Ni 1/4Mo	0.06	1.7	0.4	0.9	0.25
OE-SD3 1Ni 1/2Mo	0.07	1.7	0.3	0.9	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)				
					-20°C	-30°C	-40°C	-50°C	-60°C
OE-S2	AW	≥400	480-610	≥27	≥140	≥100	≥60		
OE-SD3	AW	≥470	530-580	≥25			≥70	≥47	
OE-S2Mo	AW	≥470	550-620	≥21	≥110		≥80	≥47	
OE-SD3 1Ni 1/4Mo	AW	≥510	600-650	≥23					≥60
OE-SD3 1Ni 1/4Mo	PWHT 620°C/1h	≥490	580-620	≥24			60		
OE-SD3 1Ni 1/2Mo	AW	≥550	620-760	≥21				≥47	
OE-SD3 1Ni 1/2Mo	PWHT 620°C/1h	≥550	620-760	≥21			≥47		

Remark: All results are in Multirun

* AW = As welded, PWHT = Post Weld Heat Treatment. All results are in Multirun

FLUX CHARACTERISTICS

Current type	AC; DC+
Basicity (Boniszewski)	1.5
Grain size (EN ISO 14174)	2-20
Redrying	300-350°C x min. 2h

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
DRY BAG	25.0	W000280015
	500.0	W000280020
	1000.0	W000402778
BIG BAG	400.0	W000375396

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.
Please refer to www.lincolnelectric.eu for any updated information.