OP 90W

TOP FEATURES

- Designed for P91 and P92 grades
- High hot cracking resistance at high interpass temperatures
- High impact toughness
- Recommended to be combined with OE-S1 CrMo91 and OE-S1 CrMo92 wires

CLASSIFICATION

Flux	EN ISO 14174: S A FB 1 55 DC H5
Flux/wire	AWS A5.23
OE-S1 CrMo91	F9PZ-EB91-B91
OE-S1 CrMo92	F9PZ-EG-G

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

Wire grade	C	Mn	Si	Cr	Ni	Mo	Nb	V	W	N
OE-S1 CrMo91	0.10	0.7	0.2	8.5	0.4	0.95	0.05	0.2		0.04
OE-S1 CrMo92	0.10	0.7	0.2	8.5	0.5	0.4	0.05	0.2	1.7	0.04

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	0°C
OE-S1 CrMo91	PWHT 760°C/4h	≥540	620-760	≥17	≥50	≥27
OE-S1 CrMo92	PWHT 760°C/4h	≥540	620-760	≥17	≥50	

* PWHT = Post Weld Heat Treatment

FLUX CHARACTERISTICS

Current type	DC+
Basicity (Boniszewski)	3.0
Grain size (EN ISO 14174)	2-16
Redrying	300-350°C x min. 2h

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
DRY BAG	25.0	W000374906

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.