

OP 190

TOP FEATURES

- Nice bead surface and good slag detachability
- Excellent profile of fillet welds
- High current carrying capacity.

CLASSIFICATION

Flux	EN ISO 14174: S A AB 1 67 AC H5		
Flux/wire	AWS A5.17	AWS A5.23	EN ISO 14171-A
OE-S1	F6A0-EL12		
OE-S2	F7A5/F6P5-EM12K		S 38 4 AB S2
OE-SD2	F7A5/F6P5-EM12K		S 38 5 AB S2Si
OE-S2Mo		F8A5/F8P2-EA2-A4	S 46 5 AB S2Mo

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

Wire grade	C	Mn	Si	Mo
OE-S1	0.05	1.0	0.2	
OE-S2	0.06	1.35	0.2	
OE-SD2	0.06	1.35	0.4	
OE-S2Mo	0.06	1.35	0.2	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-20°C	-40°C	-46°C
OE-S1	AW	>360	420-520	>24	>47		
OE-S2	AW	≥400	510-690	≥22		≥80	≥47
OE-S2	PWHT 620°C/1h	≥340	430-550	≥22		≥60	≥27
OE-SD2	AW	≥400	480-600	≥22		≥100	≥80
OE-S2Mo	AW	≥500	600-680	≥22		≥60	≥47
OE-S2Mo	PWHT 620°C/1h	≥480	560-670	≥22		≥47	

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

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	W000384243

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.