

OP 128TT

TOP FEATURES

- Highly basic flux for multiple passes applications
- Easy slag removal even in narrow groove
- High current carrying capacity making it suitable for high productivity procedures
- Excellent behavior in multi arc and long stick-out process.

CLASSIFICATION

Flux	EN ISO 14174: SA FB 1 55 AC H5		
Flux/wire	AWS A5.17	AWS A5.23	EN ISO 14171-A
OE-S2	F7A6-EM12K		
OE-SD2	F7A6-EM12K		
OE-SD3	F7A8/F7P8-EH12K		S 46 6 FB S3Si
OE-S2Mo		F8A4-EA2-A2	
OE-SD3Mo		F8A6/F8P6-EA4-A4	
OE-SD3 1Ni 1/4Mo		F8A10-ENi5-Ni5	
OE-SD3 1Ni 1/2Mo		F9A8-EF3-F3	
OE-S2 CrMo1		F8P4-E2R-B2	
OE-S1 CrMo2		F8P2-EB3R-B3	

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

Wire grade	C	Mn	Si	Cr	Ni	Mo
OE-S2	0.07	0.9	0.2			
OE-SD2	0.06	1.1	0.3			
OE-SD3	0.07	1.6	0.3			
OE-S2Mo	0.07	0.9	0.2			0.5
OE-SD3Mo	0.08	1.4	0.2			0.5
OE-SD3 1Ni 1/4Mo	0.07	1.4	0.3		0.9	0.2
OE-SD3 1Ni 1/2Mo	0.07	1.5	0.3		0.95	0.5
OE-S2 CrMo1	0.07	0.9	0.3	1.1		0.5
OE-S1 CrMo2	0.08	0.6	0.3	2.2		1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)			
					0°C	-20°C	-40°C	-60°C
OE-S2	AW	≥360	450-550	≥28	≥160	≥100	≥50	
OE-SD2	AW	≥400	480-550	>27			>100	
OE-SD3	AW	≥460	530-630	≥25	≥180		≥100	≥70
OE-SD3	PWHT 620°C/1h	≥400	480-550	>24		≥120	≥100	≥70
OE-S2Mo	AW	≥470	550-680	≥24	≥120	≥100	≥50	
OE-SD3Mo	PWHT 620°C/1h	≥530	580-620	>24			≥70	≥47
OE-SD3Mo	AW	≥540	600-650	≥22			≥60	≥30
OE-SD3 1Ni 1/2Mo	AW	≥550	650-750	≥20	≥120	≥90	≥70	≥47
OE-SD3 1Ni 1/4Mo	AW	≥500	570-630	≥22			≥145	≥70
OE-S2 CrMo1	PWHT 680°C/2h	≥380	530-630	≥24	≥50	≥80	>180	
OE-S1 CrMo2	PWHT 720°C/8h	≥450	550-650	≥22	≥30	≥50	>100	

*AW = As welded; PWHT = Post weld heat treatment

FLUX CHARACTERISTICS

Current type	AC; DC+
Basicity (Boniszewski)	2.2
Grain size (EN ISO 14174)	2-20

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
DRY BAG	25.0	W000374083
	1000.0	W000374085

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.