OP F500

TOP FEATURES

- Neutral agglomerated flux
- Excellent behavior on stabilized stainless steel grades
- Excellent slag detachability even at high interpass temperatures

CLASSIFICATION

Flux	EN ISO 14174: S A FB 2

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

Wire grade	C	Mn	Si	Cr	Ni	Mo	Nb	Cu	N
OE-308L	0.02	1.5	0.5	18	9	-	-	≤0.35	-
OE-309L	0.02	1.5	0.5	22	13	-	-	-	-
OE-309LMo	0.02	1.5	0.5	20	14	2.5	-	-	-
OE-316L	0.02	1.5	0.5	18	10	2.5	-	-	-
OE-318	0.07	1.5	0.5	18	10	2.5	-	-	-
OE-347	0.07	1.5	0.5	18	9	-	1	≤0.35	-
OE-S 22 09 / ER329N	0.03	1.5	0.5	22	8.5	3	-	-	0.18
OE-410	0.06	0.3	0.6	12	-	-	-	-	-
OE 410NiMo	0.015	0.3	0.6	12	4.2	0.5	-	-	-

- = not specified

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-20°C	+60°C
OE-308L	AW	≥350	≥500	≥35	≥75	-
OE-309L	AW	≥400	≥550	≥30	≥70	≥70
OE-309LMo	AW	≥370	≥550	≥25	≥65	-
OE-316L	AW	≥350	≥520	≥30	≥75	-
OE-318	AW	≥390	≥600	≥30	-	≥100
OE-347	AW	≥500	≥570	≥30	-	≥70
OE-S 22 09 / ER329N	AW	≥600	≥700	≥30	≥50	-

* AW = As welded

FLUX CHARACTERISTICS

Current type	AC, DC+
Basicity (Boniszewski)	2.2
Grain size (EN ISO 14174)	2-16
Redrying	300-350°C x min. 2h

AVAILABLE SIZES AND PACKAGING INFORMATION

Packaging	Weight (kg)	Item number
DRY BAG	25.0	W000402727

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.