# OP 122

## TOP FEATURES

- Usable in DC and AC polarity
- Excellent slag removal
- High current carrying capacity
- Recommended for large throat fillet welds

## CLASSIFICATION

| | | |
|---|---|---|
| **Flux** | EN ISO 14174: SA FB 1 65 AC H5 | |
| **Flux/wire** | AWS A5.17 | AWS A5.23 |
| OE-S2 | F7A5/F6P5-EM12K | |
| OE-SD3 | F7A4/F6P4-EH12K | |
| OE-S2Mo | | F7A2-EA2-A2 |

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

| Wire grade | C | Mn | Si | Mo |
|---|---|---|---|---|
| OE-S2 | 0.07 | 1.0 | 0.2 | |
| OE-SD3 | 0.07 | 1.5 | 0.3 | |
| OE-S2Mo | 0.07 | 1.0 | 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 | 0°C | -20°C | -40°C |
| OE-S2 | AW | ≥400 | 450-550 | ≥24 | ≥150 | ≥110 | ≥90 | |
| OE-SD3 | AW | ≥400 | 500-600 | ≥24 | ≥160 | ≥130 | ≥100 | ≥70 |
| OE-S2Mo | AW | ≥480 | 550-650 | ≥20 | ≥90 | ≥70 | ≥40 | |

* AW = As welded

## FLUX CHARACTERISTICS

| | |
|---|---|
| Current type | AC; DC+ |
| Basicity (Boniszewski) | 1.7 |
| Grain size (EN ISO 14174) | 2-20 |
| Redrying | 300-350°C x 2-4h |

## PACKAGING AND AVAILABLE SIZES

| Packaging | Weight (kg) | Item number |
|---|---|---|
| DRY BAG | 25.0 | W000400118 |
| | 400.0 | W000379124 |

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.