OP 1350A

TOP FEATURES

- Hardfacing alloying flux in Carbon, Chromium and Molybdenum
- Recommended with OE-S2 and OE-S2Mo wires
- Maximum hardness of 330HB with OE-S2

CLASSIFICATION

Flux	EN ISO 14174: SA CS 3

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

Wire grade	Layer	C	Mn	Si	Cr	Mo
OE-S2	1	0.1	1.5	0.6	1.2	0.2
OE-S2	2	0.1	1.7	0.7	1.4	0.2
OE-S2	3	0.1	1.9	0.9	1.9	0.3
OE-S2Mo	1	0.1	1.5	0.6	1.3	0.4
OE-S2Mo	2	0.1	1.7	0.8	1.5	0.5
OE-S2Mo	3	0.1	1.9	1.0	2.1	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Layer	Condition*	Hardness (HB)
OE-S2	1	AW	260
OE-S2	2	AW	320
OE-S2	3	AW	330
OE-S2Mo	1	AW	280
OE-S2Mo	2	AW	370
OE-S2Mo	3	AW	390

* AW = As welded

FLUX CHARACTERISTICS

Current type	AC; DC+
Grain size (EN ISO 14174)	2-20
Redrying	300-350°Cx2-4h

PACKAGING AND AVAILABLE SIZES

Packaging	Weight (kg)	Item number
DRY BAG	25.0	W000280090

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.