OP 87

TOP FEATURES

- Designed for strip cladding. Can be used for welding as well
- Low basicity flux for an enhanced operability
- Compatible with stabilized stainless steel grades

CLASSIFICATION

Flux	EN ISO 14174: SA CS 2

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

Wire grade	C	Cr	Ni	Mo	Nb
OE-308L	0.03	18	9		
OE-316L	0.03	18	10	2.5	
OE-318	0.07	18	10	2.5	≥8xC
OE-347	0.07	18	9		≥8xC

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
OE-308L	AW	≥350	≥550	≥35	≥75
OE-316L	AW	≥370	≥550	≥30	≥75
OE-318	AW	≥370	≥600	≥30	≥65
OE-347	AW	≥350	≥575	≥30	≥65

* AW = As welded

FLUX CHARACTERISTICS

Current type	AC, DC+
Basicity (Boniszewski)	1
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	W000280076

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.