

SAW Fluxes Stainless and Heat resistant steels

OP 70Cr Spezial is an agglomerated flux of the fluoride-basic type for welding austenitic stainless and heat resisting steels. Regarding the carbon and silicon content of the weld metal, OP 70Cr Spezial is strictly neutral, which means that neither pick-up nor burn-out will occur. OP 70Cr Spezial donates a small amount of manganese and contains chromium components to assure that the chromium level of the wire will be maintained in the weld deposit.

The high resistance to cracking and low diffusible hydrogen level of the deposited weld metal makes OP 70Cr Spezial the ideal flux for welding heavy sections of stainless steels. Due to its good slag release OP 70Cr Spezial is particularly suited for narrow gap applications. Weld seams are smooth and finely rippled without any undercut into the base metal.

DC+ is recommended. Damp flux should be re-dried at 300-350°C. Grain size according to EN 760: 2-20.

Wire	Classification
	EN 760: SA FB 2 57 H5

Wire	Approvals	Grades

Flux Analysis	
SiO ₂ + TiO ₂	10 %
Al ₂ O ₃ + MnO	20 %
CaF ₂	30 %
CaO + MgO	35 %

Basicity to Boniszewski 2,8

Typical Applications

Wire	Materials
OE-308L	ASME:AISI 304 - 304L - 302 EN:X 2 Cr Ni 18 8 (1.4300), X 5 Cr Ni 18 8 (1.4301), X 2 Cr Ni 19 11 (1.4306)

Analysis of all-weld metal (Typical values in %)

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OE-308L	0.027	1.60	0.30	19.20	10.50	-	-	-	-

All-weld metal Mechanical Properties

Wire	Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)
OE-308L	As Welded	≥ 210	520 - 670	≥ 30

All-weld metal Mechanical Properties - Cv

Wire	Heat Treatment	Charpy V Notch Impact Toughness (J)							
		+20	0	- 20	- 30	- 40	- 60	- 80	- 101
OE-308L	As Welded	25 min	-	-	-	-	-	-	-

Packaging data

25kg heavy duty sealed polythene sacks

Further forms of delivery on request.

Current condition

DC+