

SAW Fluxes Stainless and Heat resistant steels

OP 77 is a fused flux, developed to give good weldability on AC current up to 900A on a single electrode. Very well adapted for horizontal welding, but can be used in flat position for butt and fillet welds. Particularly recommended for welding 9% nickel steel in cryogenic (LPG/LNG) applications such as tank fabrication with OE-S C276 wire. Very low moisture pick-up and good slag detachment. When horizontal welding gives flat wettability and limited weld reinforcement. Good distribution of the flux and good uniformity of the slag in the 2G position.

Wire	Classification
	EN 760: SF CS 2 65 AC H5

Wire	Approvals	Grades

Flux Analysis	
SiO ₂	28 %
CaO + CaF ₂ + MgO	55 %
Al ₂ O ₃ + TiO ₂ + ZrO ₂	10 %

Basicity to Boniszewski 1,3

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

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OE-S C276	0.013	0.60	0.30	15.50	Rem	16	-	-	-

All-weld metal Mechanical Properties

Wire	Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)
OE-S C276	As Welded	≥ 360	600-700	≥ 35

All-weld metal Mechanical Properties - Cv

Wire	Heat Treatment	Charpy V Notch Impact Toughness (J)							
		+20	0	- 20	- 30	- 40	- 50	- 60	- 196
OE-S C276	As Welded	-	-	-	-	-	-	-	100 min

Packaging data

25kg heavy duty sealed polythene sacks

Further forms of delivery on request.

Current condition

AC; DC+