

SAW Fluxes Stainless and Heat resistant steels

OP XNi is a basic welding flux designed for being used in combination with nickel base wire electrodes. It features an excellent slag detachability and a high resistance to the formation of hot cracks. OP XNi is suitable for joint welding and cladding of small surfaces with wire electrodes. Damp flux should be re-dried at 300-350°C. Grain size according to EN-ISO 14174: 2-16.

Classification

EN ISO	14174: SA AB 2
EN	760: SA AB 2 AC H5

Flux Main Components

Al ₂ O ₃ + MnO	47 %
CaF ₂	20 %
CaO + MgO	18 %
SiO ₂ + TiO ₂	6 %

Boniszewski Basicity 2

Chemical analysis (Typical values in %)

		C	Mn	Si	Cr	Ni	Mo	Nb	Fe
All weld metal	OE-NIFIL 600	0.02	4	0.35	21.5	70	-	2.5	0.8
All weld metal	OE-NIFIL 625	0.015	2	0.4	21	60	9	3.5	0.5

All-weld metal Mechanical Properties

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation
OE-NIFIL 600	As Welded	≥ 350	≥ 600	≥ 42
OE-NIFIL 625	As Welded	≥ 460	≥ 730	≥ 42

All-weld metal Mechanical Properties - CV

	Heat Treatment	Impact Energy (J) -196 °C
OE-NIFIL 600	As Welded	≥ 95
OE-NIFIL 625	As Welded	≥ 80

Typical applications

	Materials
OE-NIFIL 625	ASME: SA353-70; SA553-70; UNS N06625; UNS N08825 EN: 2.4816; 1.4876; 1.4958; X7Ni9 (1.5663); X8Ni9 (1.5662)
OE-NIFIL 600	ASME: UNS N06600; UNS N08800; UNS N08810 EN: 2.4816; 1.4876; 1.4958

Redrying

300-350°Cx2-4h

Current Conditions

AC; DC+