

# PRODUCT DATA SHEET

## Oerlikon OE-N 127



Oerlikon OE-N 127 is a basic, low hydrogen, low alloy CrNiMo type electrodes with high strength for cast steels up to 1 000 MPa tensile strength. Good weldability in all positions. Low splatter loss. Easy slag removal. Smooth bead appearance. Suitable for similar steels that require heat treatment after welding. Observe the requirements for preheating and post weld heat treatment of the base material to avoid cracking.

### Re-drying

Only dry electrodes should be used. Re-drying should be carried out at 300-350°C for 2 hours.

### Classifications

AWS	A5.5	E12018-G
EN	757	E89 A Z H5

### Typical Chemical Analysis

% Carbon	0,1	% Chromium	2,2
% Manganese	1,2	% Molybdenum	0,5
% Silicon	0,3	% Nickel	1,2

### Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Strength	>900 MPa
Tensile Strength	1 000 - 1 100 MPa
% Elongation on 5d	>12
Impact Strength at +20°C ISO-V	>25 J

### Packing Data (DC+)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Pieces per Carton (approx)	Item Number
4,0	450	140 - 180	5,0	65	W112074
5,0	450	190 - 230	5,0	47	W112075

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