OK Flux 10.11

OK Flux 10.11 is a very high basic agglomerated flux for electroslag strip cladding. The flux has low viscosity and is suitable for cladding with Ni-base, Co and fully-austenitic alloys due to its good wetting behavior. It is also suitable for welding at higher travel speeds.

Specifications	
Classifications	EN ISO 14174 : ES A FB 2B 56 44 DC

Welding Current	approx. 2500 (90 x 0.5 mm strip)
Slag Type	Fluoride basic CaF2-Al2O3
Alloy Transfer	Moderately silicon alloying
Density	nom: 1.0 kg/dm3
Basicity Index	nom: 5.4

Classifications	
Wire	**AWS/EN**
OK Band NiCrMo3	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)
OK Band NiFeCr1	A5.14:EQNiFeCr-1/ 18274:B Ni 8065 (NiFe30Cr21Mo3)

Approvals
Combined with Wire
*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Al**	**Cu**
OK Band NiCrMo3									
0.04	0.08	0.50	-	-	Bal.	20.1	8.1	-	0.01
OK Band NiFeCr1 1250A, 24V, 18cm/min.									
0.018	0.5	0.85	-	-	38.5	20.0	2.9	-	1.8
OK Band NiFeCr1									
-	-	-	0.001	0.015	-	-	-	0.03	-

Typical Weld Metal Analysis %		
Ti	**Fe**	**Nb+Ta**
OK Band NiCrMo3		
-	6.0	2.8
OK Band NiFeCr1 1250A, 24V, 18cm/min.		
0.1	31.0	-

Typical Wire Composition %									
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**Cu**	**Ti**	**Fe**	**Nb+Ta**
OK Band NiCrMo3									
<0.1	0.3	0.1	58.0	22.0	9.0	-	-	2.0	4.0
OK Band NiFeCr1									
0.01	0.78	0.3	42.5	22.5	3.0	2.2	1.0	>22.0	-