

OK Flux 10.14

This flux/strip-combination is used for electrosag strip cladding giving low carbon, Mo-alloyed 316L material in the first layer. The Mo increases the resistance to pitting corrosion. The flux properties permit to use higher travel speeds, up to about 30 cm/min, with significantly increased cladding productivity.

Specifications

Classifications	EN ISO 14174 : ES A FB 2B 56 44 DC
Welding Current	approx. 2500 A
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃
Alloy Transfer	Moderately silicon alloying
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 4.4

Classifications

Wire	AWS/EN
OK Band 309LMo ESW	A5.9:EQ309LMo (Mod)/ 14343-A:B 21 13 3 L
OK Band 309LNb	14343-A:B 23 12 L Nb

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	Cu	N
OK Band 309LMo ESW									
0.030	1.38	0.37	0.003	0.017	11.7	17.4	2.43	0.08	0.03
OK Band 309LNb									
0.04	1.6	0.5	0.01	0.01	10.0	19.0	0.02	-	0.02

Typical Weld Metal Analysis %

Nb	Ferrite FN	FN WRC-92
OK Band 309LMo ESW		
-	6	4
OK Band 309LNb		
0.6	9	5

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N	Nb	Ferrite FN
OK Band 309LMo ESW								
0.015	1.8	0.2	13.5	20.5	2.9	0.06	-	13
OK Band 309LNb								
0.01	1.98	0.23	12.5	23.83	-	0.03	0.7	23