

## OK Flux 10.95

This flux/wire combination is designed for welding of stainless chromium nickel alloys. The weld metal is austenitic with adequate amount of ferrite and offers good resistance to uniform corrosion. The flux is slightly Ni-alloying and thus the ferrite content is kept on a low level. This has a positive effect on the impact values at low temperature.

Specifications	
Classifications	EN ISO 14174 : S A AF 2 56 44 Ni DC

Slag Type	Fluoride basic CaF <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> -SiO <sub>2</sub>
Alloy Transfer	Nickel alloying
Density	nom: 1.0 kg/dm <sup>3</sup>
Basicity Index	nom: 2.0

Flux Consumption	
Volts	kg Flux / kg Wire DC+
34 V	0.8 kg
30 V	0.6 kg
26 V	0.5 kg
38 V	1.0 kg

Conditions : Dimension 4.0 mm , Amps 580 A , Travel speed 33 m/h

Classifications	
Wire	AWS/EN
OK Autrod 308L	A5.9:ER308L/ 14343-A:S 19 9 L

Approvals	
Combined with Wire	
*Selected production units only. Please contact ESAB for more information. Visit <a href="http://esab.com">esab.com</a> to download specific flux/wire combination fact sheets for more details.	

Typical Weld Metal Analysis %						
C	Mn	Si	Ni	Cr	N	FN WRC-92
OK Autrod 308L Current: DC+, 420A, 27V						
<0.03	1.4	0.6	11.0	20.0	0.06	5

Typical Wire Composition %					
C	Mn	Si	Ni	Cr	N
OK Autrod 308L					
0.02	1.9	0.4	9.8	19.8	0.05

Typical Mechanical Properties					
Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 308L	As Welded DC+	400 MPa ( 58 ksi )	540 MPa ( 78 ksi )	40 %	80 J @ -60 °C ( 59 ft-lb @ -76 °F ) 70 J @ -110 °C ( 52 ft-lb @ -166 °F ) 50 J @ -196 °C ( 37 ft-lb @ -320.8 °F )