OK Flux 10.17

Agglomerated fluoride basic flux in combination with a nickel-base wire of the 625-type. OK Flux 10.17 has very good welding characteristics giving a smooth bead appearance and an easy slag removal. The combination is suitable for welding similar base material and for dissimilar joint.

Specifications	
Classifications	EN ISO 14174 : S A FB 2B 57 24 DC

Welding Current	900 A (60 x 0.5 mm strip)
Slag Type	Aluminate-fluoride-basic, Al2O3-CaF2
Alloy Transfer	Moderately silicon alloying
Density	nom: 1,1 kg/dm³
Basicity Index	nom: 2,5

Classifications	
Wire	**SFA/AWS - EN ISO**
OK Autrod NiCrMo-3	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr22Mo9Nb)
OK Band NiCrMo3	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)

Approvals
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**	**Fe**
OK Autrod NiCrMo-3									
-	-	-	0.01	0.01	-	-	-	0.08	-
OK Autrod NiCrMo-3 DC+, 300A, 29V, dia 2,4 mm									
0.01	0.1	0.5	-	-	Bal.	21,5	8.5	-	1
OK Band NiCrMo3									
-	-	-	0.01	0.01	-	-	-	-	-
OK Band NiCrMo3 DC+, 850A, 28V, 12cm/min									
0.03	0.1	0.6	-	-	61	19.6	8.0	-	9

Typical Weld Metal Analysis %
Nb+Ta
OK Autrod NiCrMo-3 DC+, 300A, 29V, dia 2,4 mm
3.2
OK Band NiCrMo3
2.9
OK Band NiCrMo3 DC+, 850A, 28V, 12cm/min
2.7

Typical Wire Composition %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**Fe**	**Nb+Ta**
OK Autrod NiCrMo-3							
0.02	0.04	0.06	Bal	22.7	8.6	0.3	3.5
OK Band NiCrMo3							
<0.1	0.3	0.1	58.0	22.0	9.0	2.0	4.0

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Typical Mechanical Properties					
Wire	**Condition**	**Yield Strength**	**Tensile Strength**	**Elongation**	**Charpy V-Notch**
OK Autrod NiCrMo-3	As Welded HI ~1.0-1.6 kJ/mm DC+	460 MPa	710 MPa	44 %	65 J @ -196 °C