

OK Flux 10.95

Basic, nickel alloying, agglomerated flux for butt welding of stainless steels. Specially recommended for welding of stainless steels when impact strength at low temperatures is required. Low Si addition during welding provides good mechanical properties in the weld metal.

Specificaties

Classificaties	EN ISO 14174 : S A AF 2 56 44 Ni DC
Slaktype	Fluoride basic CaF ₂ -Al ₂ O ₃ -SiO ₂
Legering Transfer	Nickel alloying
Dichtheid	nom: 1.0 kg/dm ³
Basiciteits Index	nom: 2.0

Fluxverbruik

Volt	kg Flux / kg Draad DC+
34 V	0.8 kg
30 V	0.6 kg
26 V	0.5 kg
38 V	1.0 kg

Conditionering : Afmeting 4.0 mm , Ampère 580 A , Voortloopsnelheid 33 m/h

Normen

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

Goedkeuringen

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

draad samenstelling

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

Typische lasmetaalanalyse (%)

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

Typische mechanische eigenschappen

Draad	Conditionering	Rekgrens	Treksterkte	Rek	Charpy V-groef
OK Autrod 308L	Zoals gelast DC+	400 MPa	540 MPa	40 %	80 J @ -60 °C 70 J @ -110 °C 50 J @ -196 °C