

OK Flux 10.10

OK Flux 10.10 is an agglomerated flux designed for electroslag strip surfacing. This flux is particular suitable for strip surfacing with stainless strips of the Cr, CrNi and CrNiMo types, with or without Nb stabilization. The weldability, bead appearance and slag removal of OK Flux 10.10 are excellent.~OK Flux 10.10 together with OK Band 309L produces a 308L weld deposit analysis in one layer.~OK Flux 10.10 together with OK Band 309LNb produces a 347 weld deposit analysis in one layer.~Ok Flux 10.10 together with OK Band 309Lmo produces a 316L weld deposit analysis in one layer.~

Specifications	
Classifications	EN ISO 14174 : ES A FB 2B 56 44 DC
Approvals	NAKS/HAKC : RD 03-613-03

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	1700 A (60 x 0.5 mm strip)
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: 4.0

Condition : Volts 25 V , kg Flux / kg Wire DC+ 0.5 kg , Amps 1250 A , Travel speed 9 m/h

Classifications		
Wire	AWS/EN	AWS - As Welded
OK Band 309L ESW	14343-A:B 22 11 L	-
OK Band 309Lmo ESW	A5.9:EQ309Lmo (Mod)/ 14343-A:B 21 13 3 L	-
OK Band 309LNb ESW	14343-A:B 22 12 L Nb	A5.39: ESCLAD1-EQ309L(mod)/347
OK Band 430	14343-A:B 17	A5.39: ESCLAD2-EQ430(mod)/430

Approvals	
Combined with Wire	VdTÜV
OK Band 309LNb ESW	•

Typical Wire Composition %									
C	Mn	Si	Ni	Cr	Mo	N	Nb	Ferrite FN	FN WRC-92
OK Band 309L ESW									
0.010	1.8	0.2	11.0	21.1	-	0.05	-	-	15
OK Band 309Lmo ESW									
0.015	1.8	0.2	13.5	20.5	2.9	0.06	-	13	-
OK Band 309LNb ESW									
0.01	1.74	0.20	11.0	21.14	-	0.04	0.6	-	15
OK Band 430									
0.04	0.66	0.4	-	17.0	-	-	-	-	-

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
OK Band 309L ESW									
0.03	1.2	0.4	0.001	0.002	10.0	19.0	0.2	0.1	0.05
OK Band 309Lmo ESW									
0.02	1.1	0.4	0.001	0.008	12.5	18.0	2.8	0.1	0.04
OK Band 309LNb ESW									
0.03	1.3	0.5	0.001	0.01	10.0	19.0	0.1	0.1	0.05
OK Band 430									
0.06	0.3	0.6	0.005	0.03	0.2	13.3	0.1	0.2	-

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Typical Weld Metal Analysis %		
Nb	FN WRC-92	O
OK Band 309L ESW		
-	4	0.02
OK Band 309LMo ESW		
-	6	-
OK Band 309LNb ESW		
0.4	4	-