

OK Flux 10.05

OK Flux 10.05 is an agglomerated flux for submerged arc strip cladding. It is recommended for cladding with the Cr, CrNi and CrNiMo types of stainless strips. Slag removal and overlapping with this flux are excellent.

Specifications	
Classifications	EN ISO 14174 : S A AAS 2B 56 34 DC
Approvals	NAKS/HAKC : RD 03-613-03
Industry	Petrochemical Process Industry

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

Welding Current	1000 A (60 x 0.5 mm strip)
Slag Type	Acid-aluminium-silicate Al ₂ O ₃ -SiO ₂ -CaF ₂ -MgO
Alloy Transfer	Non alloying
Density	nom: 0.7 kg/dm ³
Basicity Index	nom: 1.1

Flux Consumption	
Volts	kg Flux / kg Wire DC+
32 V	0.6 kg
28 V	0.5 kg
25 V	0.4 kg

Condition : Dimension 60 x 0.5 mm , Amps 750 A , Travel speed 7 m/h

Classifications	
Wire	AWS/EN
OK Band 308L	A5.9:EQ308L/ 14343-A:B 19 9 L
OK Band 309LNb	14343-A:B 23 12 L Nb
OK Band 316L	A5.9:EQ316L/ 14343-A:B 19 12 3 L
OK Band 347	A5.9:EQ347/ 14343-A:B 19 9 Nb

Approvals	
Combined with Wire	VdTÜV
OK Band 316L	•

Typical Wire Composition %								
C	Mn	Si	Ni	Cr	Mo	N	Nb	FN WRC-92
OK Band 308L								
0.015	1.8	0.3	10.5	20.0	-	0.06	-	12
OK Band 309LNb								
0.01	1.98	0.23	12.5	23.83	-	0.03	0.7	23
OK Band 316L								
0.01	1.73	0.4	12.6	18.5	2.9	0.05	-	7
OK Band 347								
0.02	1.8	0.37	10.0	19.5	-	0.06	0.5	11

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
OK Band 308L									
0.02	1.0	0.6	0.01	0.02	10.5	19.0	0.1	0.03	0.03

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Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
OK Band 309LNb									
0.03	1.1	0.6	0.01	0.02	10.0	19.0	0.2	0.1	0.04
OK Band 316L									
0.02	1.1	0.7	0.01	0.02	13.0	18.0	2.5	0.3	0.02
OK Band 347									
0.02	1.1	0.7	0.005	0.02	10.5	19.0	0.1	0.05	0.03

Typical Weld Metal Analysis %	
Nb	FN WRC-92
OK Band 308L	
0.01	6
OK Band 309LNb	
0.35	5
OK Band 316L	
0.05	7
OK Band 347	
0.35	8