

OK Flux 10.11

Very high basic agglomerated flux for electro slag strip cladding. The flux has a low viscosity and is suitable for cladding with Ni base, Co and fully austenitic alloys due to its good wetting behaviour. Also suitable for welding with higher travel speeds.

Specifikace

Klasifikace	EN ISO 14174 : ES A FB 2B 56 44 DC
Svaovací proud	approx. 2500 (90 x 0.5 mm strip)
Typ strusky	Fluoride basic CaF ₂ -Al ₂ O ₃
Zmna legování	Moderately silicon alloying
Hustota	nom: 1.0 kg/dm ³
Index bazicity	nom: 5.4

Klasifikace

Svaovací drát	AWS/EN
OK Band NiCrMo3	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)
OK Band NiFeCr1	A5.14:EQNiFeCr-1/ 18274:B Ni 8065 (NiFe30Cr21Mo3)

Schválení

Svaovací drát

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

Typické složení drátu %

C	Mn	Si	Ni	Cr	Mo	Cu	Ti	Fe	Nb+Ta
OK Band NiCrMo3									
<0.1	0.3	0.1	58.0	22.0	9.0	-	-	2.0	4.0
OK Band NiFeCr1									
0.01	0.78	0.3	42.5	22.5	3.0	2.2	1.0	>22.0	-

Typického chemického složení svarového kovu v %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
OK Band NiCrMo3									
0.04	0.08	0.50	-	-	Bal.	20.1	8.1	-	0.01
OK Band NiFeCr1 1250A, 24V, 18cm/min.									
0.018	0.5	0.85	-	-	38.5	20.0	2.9	-	1.8
OK Band NiFeCr1									
-	-	-	0.001	0.015	-	-	-	0.03	-

Typického chemického složení svarového kovu v %

Ti	Fe	Nb+Ta
OK Band NiCrMo3		
-	6.0	2.8
OK Band NiFeCr1 1250A, 24V, 18cm/min.		
0.1	31.0	-