

## OK Flux 10.14

This flux/strip-combination is used for electrosag strip cladding giving low carbon, Mo-alloyed 316L material in the first layer. The Mo increases the resistance to pitting corrosion. The flux properties permit to use higher travel speeds, up to about 30 cm/min, with significantly increased cladding productivity.

### Specifications

|                        |   |
|------------------------|---|
| <b>Classifications</b> | EN ISO 14174 : ES A FB 2B 56 44 DC                              |
| <b>Welding Current</b> | approx. 2500 A  |
| <b>Slag Type</b>       | Fluoride basic CaF <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> |
| <b>Alloy Transfer</b>  | Moderately silicon alloying                                     |
| <b>Density</b>         | nom: 1.0 kg/dm <sup>3</sup>                                     |
| <b>Basicity Index</b>  | nom: 4.4  |

### Classifications

|                    |  |
|--------------------|--|
| <b>Wire</b>        | <b>SFA/AWS - EN ISO</b>                  |
| OK Band 309LMo ESW | A5.9:EQ309LMo (Mod)/ 14343-A:B 21 13 3 L |
| OK Band 309LNb     | 14343-A:B 23 12 L Nb                     |

### Approvals

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| <b>Wire</b>  |
| *Selected production units only. Please contact ESAB for more information. Visit <a href="http://esab.com">esab.com</a> to download specific flux/wire combination fact sheets for more details. |

### Typical Weld Metal Analysis %

|                    |
|--------------------|
| OK Band 309LMo ESW |
| OK Band 309LNb     |

### Typical Wire Composition %

|                    |
|--------------------|
| OK Band 309LMo ESW |
| OK Band 309LNb     |