

OK Flux 10.07

Neutral, agglomerated, nickel- and molybdenum alloying flux, specially designed for strip cladding with a 17Cr-strip, producing a weld metal with 14Cr-4Ni-1Mo and a hardness of 370-420 HB. Can also be used for cladding with a 17Cr-wire producing the same weld metal.

Specifications	
Classifications	EN ISO 14174 : S A GS 3 Ni4 Mo1 DC
Welding Current	1000 A
Slag Type	Calcium silicate SiO ₂ -MgO-Al ₂ O ₃ -(CaF ₂)
Alloy Transfer	Nickel and molybdenum alloying
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 1.0

Flux Consumption
Volts
28 V
26 V

Condition : kg Flux / kg Wire DC+ 0.65 kg , Dimension 60 x 0.5 mm , Amps 750 A , Travel Speed 7 m/h

Classifications	
Wire	SFA/AWS - EN ISO
OK Band 430	14343-A:B 17

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

Typical Weld Metal Analysis %							
C	Mn	Si	S	P	Ni	Cr	Mo
OK Band 430							
-	-	-	0.01	0.02	-	-	-
OK Band 430 Current: DC+, 770A, 25V, 22 cm/min							
0.05	0.15	0.6	-	-	4.0	13.0	1.0

Typical Wire Composition %			
C	Mn	Si	Cr
OK Band 430			
0.04	0.66	0.4	17.0