OK Flux 10.26

OK Flux 10.26 is a high basic, agglomerated Ni-, Cr- and Mo-adding flux designed for single layer electroslag strip cladding solution. The flux has very good welding characteristics gives a smooth bead appearance and easy slag removal. It can be used to achieve 316L and 317L weld deposit chemistry in combination with equivalent strip grades.

Specifications	
Classifications	EN ISO 14174 : ES A FB 2B 54 91 NiMo DC

Slag Type	Fluoride basic
Alloy Transfer	Nickel, chromium and molybdenum
Density	nom: 1.2 kg/dm3
Basicity Index	nom: 3.0

Classifications	
Wire	**SFA/AWS - EN ISO**
19.13.4.L ESW	A5.9:EQ317L/ 14343-A:B 19 13 4 L
OK Band 316L	A5.9:EQ316L/ 14343-A:B 19 12 3 L

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 Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
19.13.4.L ESW									
<=0.02	1.5	0.4	<=0.020	<=0.020	14	19	3.6	<=0.3	-
OK Band 316L									
0.01	1.73	0.4	-	-	12.6	18.5	2.9	-	0.05

Typical Wire Composition %
FN WRC-92
19.13.4.L ESW
7
OK Band 316L
7

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
19.13.4.L ESW									
0.02	1.0	0.5	0.01	0.02	13.8	19	3.4	0.07	-
OK Band 316L									
-	-	-	0.01	0.02	-	-	-	0.1	-
OK Band 316L DC+, 1200A, 24V, 16-18 cm/min									
0.02	1.2	0.2	-	-	12.8	19.0	2.7	-	0.05

Typical Weld Metal Analysis %
FN WRC-92
19.13.4.L ESW
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OK Band 316L DC+, 1200A, 24V, 16-18 cm/min

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Typical Weld Metal Analysis %
FN WRC-92
7