

OK Flux 10.64

Agglomerated fluoride-basic flux-wire combination for Submerged Arc Welding. Especially for joining of T/P91 base materials. The flux is C and Cr compensating so that the weld metal fully complies with B91 weld metal chemistry according to AWS. Mainly for power generation and pressure vessel production. Very good slag detachability. Suitable for DC only. Single layer and multi layer welding of unlimited plate thickness.

Specifications

Classifications	EN ISO 14174 : S A FB 1 54 DC H5
Diffusible Hydrogen	max 5 ml/100g weld metal (Redried flux)
Slag Type	Fluoride-basic
Alloy Transfer	No Silicon alloying, Manganese slightly burning off
Density	nom: 1.1 kg/dm ³ Approx.
Basicity Index	nom: 2.6

Classifications

Wire	SFA/AWS - EN ISO
OK Autrod 13.35	A5.23:EB91/ 24598-A:S S CrMo91

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
OK Autrod 13.35 DC+, 400A, 28V (2,4 mm wire)									
0.11	0.65	0.25	-	-	0.55	8.8	0.90	0.17	-
OK Autrod 13.35									
-	-	-	0.009	0.009	-	-	-	-	0,015

Typical Weld Metal Analysis %

Cu	N	Nb
OK Autrod 13.35 DC+, 400A, 28V (2,4 mm wire)		
-	0.05	0.05
OK Autrod 13.35		
0,04	-	-

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	V	N	Nb
OK Autrod 13.35								
0.10	0.52	0.22	0.67	8.82	0.92	0.20	0.05	0.07