

OK Flux 10.16

High basic, all mineral, agglomerated flux designed for welding nickel and nickel based alloys. The flux is particularly suitable for strip cladding with Ni-based strip. The silicon transfer from the flux to the weld metal is strongly reduced by the well balanced flux composition and thus minimizing the risk for hot cracking in welding Ni-based alloys.

Specifications

Classifications	EN ISO 14174 : S A FB 2 55 43 DC
Approvals	NAKS/HAKC : RD 03-613-03

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	900 A (60 x 0.5 mm strip)
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Alloy Transfer	Moderately manganese and silicon alloying
Density	nom: 1.2 kg/dm ³
Basicity Index	nom: 2.4

Classifications_SAW

Wire	AWS/EN	AWS - As Welded
OK Autrod NiCrMo-3	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr22Mo9Nb)	A5.39: F100A32-ERNiCrMo-3/NiCrMo-3
OK Band NiCrMo3	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)	-

Approvals_SAW

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	Cu	N
OK Autrod NiCrMo-3 DC+, 350A, 28V, 35cm/min									
0.01	0.6	0.3	-	-	Bal.	20.7	8.5	-	-
OK Autrod NiCrMo-3									
-	-	-	0.010	0.01	-	-	-	0.02	-
OK Band NiCrMo3									
-	-	-	0.01	0.01	-	-	-	-	0.025
OK Band NiCrMo3 DC+, 750A, 27V, 13cm/min									
0.02	1.0	0.2	-	-	Bal	19.0	7.4	-	-

Typical Weld Metal Analysis %

Fe	Nb+Ta
OK Autrod NiCrMo-3 DC+, 350A, 28V, 35cm/min	
1.0	3.0
OK Band NiCrMo3	
-	2.8
OK Band NiCrMo3 DC+, 750A, 27V, 13cm/min	
12.8	2.6

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Fe	Nb+Ta
OK Autrod NiCrMo-3							
0.02	0.04	0.06	Bal	22.7	8.6	0.3	3.5

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Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Fe	Nb+Ta
OK Band NiCrMo3							
<0.1	0.3	0.1	58.0	22.0	9.0	2.0	4.0

SAW_Typical_Mech_Properties

Wire	Testing Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch Result
OK Autrod NiCrMo-3	As Welded HI ~1.0-1.7 kJ/mm DC+	450 MPa	720 MPa	50 %	110 J @ -140 °C 100 J @ -196 °C