

OK Flux 10.11

Very high basic agglomerated flux for electro slag strip cladding. The flux has a low viscosity and is suitable for cladding with Ni base, Co and fully austenitic alloys due to its good wetting behaviour. Also suitable for welding with higher travel speeds.

Especificaciones

Clasificaciones	EN ISO 14174 : ES A FB 2B 56 44 DC
Corriente de soldadura	approx. 2500 (90 x 0.5 mm strip)
Tipo de escoria	Fluoride basic CaF ₂ -Al ₂ O ₃
Transferencia de aleación	Moderately silicon alloying
Densidad	nom: 1.0 kg/dm ³
Índice de basicidad	nom: 5.4

Clasificaciones

Hilo	AWS según EN (Euro Norma)
OK Band NiCrMo3	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)
OK Band NiFeCr1	A5.14:EQNiFeCr-1/ 18274:B Ni 8065 (NiFe30Cr21Mo3)

Aprobaciones

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

% Composición hilo (valores típicos)

C	Mn	Si	Ni	Cr	Mo	Cu	Ti	Fe	Nb+Ta
OK Band NiCrMo3									
<0.1	0.3	0.1	58.0	22.0	9.0	-	-	2.0	4.0
OK Band NiFeCr1									
0.01	0.78	0.3	42.5	22.5	3.0	2.2	1.0	>22.0	-

% Análisis metal depositado (valores típicos)

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
OK Band NiCrMo3									
0.04	0.08	0.50	-	-	Bal.	20.1	8.1	-	0.01
OK Band NiFeCr1									
-	-	-	0.001	0.015	-	-	-	0.03	-
OK Band NiFeCr1 1250A, 24V, 18cm/min.									
0.018	0.5	0.85	-	-	38.5	20.0	2.9	-	1.8

% Análisis metal depositado (valores típicos)

Ti	Fe	Nb+Ta
OK Band NiCrMo3		
-	6.0	2.8
OK Band NiFeCr1 1250A, 24V, 18cm/min.		
0.1	31.0	-