

OK Flux 10.50 (Low-alloyed steels)

OK Flux 10.50 is a fused, highbasic flux for electro slag welding (vertically up). In this process, resistive heating of the liquid slag melts the wire. Deposition rates of 40 kg/h are easily achievable with multi-wire systems. The flux is suitable for single and multi-wire procedures, for DC and AC welding and is used for unlimited plate thicknesses. Once the welding process begins, the OK Flux 10.50 suppresses the welding arc. Water-cooled copper bars that slide vertically-up parallel to the proceeding welding process support the molten weld pool. The mechanical values of the weld metal can be influenced by the choice of the wire electrode or welding procedure. Due to the high dilution the base material also has a major influence. Electro slag welding vertically-up can be applied to a wide range of steels such as structural steels, fine-grained steels and pressure vessel steels.