

## OK Flux 10.95

Basic, nickel alloying, agglomerated flux for butt welding of stainless steels. Specially recommended for welding of stainless steels when impact strength at low temperatures is required. Low Si addition during welding provides good mechanical properties in the weld metal.

| Especificaciones                                                                                                                                                   |                                     |                       |                           |              |                                                   |           |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|-----------------------|---------------------------|--------------|---------------------------------------------------|-----------|
| Clasificaciones                                                                                                                                                    | EN ISO 14174 : S A AF 2 56 44 Ni DC |                       |                           |              |                                                   |           |
|                                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| Tipo de escoria                                                                                                                                                    | Fluoride basic CaF2-Al2O3-SiO2      |                       |                           |              |                                                   |           |
| Transferencia de aleación                                                                                                                                          | Nickel alloying                     |                       |                           |              |                                                   |           |
| Densidad                                                                                                                                                           | nom: 1.0 kg/dm3                     |                       |                           |              |                                                   |           |
| ?ndice de basicidad                                                                                                                                                | nom: 2.0                            |                       |                           |              |                                                   |           |
|                                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| El Consumo de Flujo                                                                                                                                                |                                     |                       |                           |              |                                                   |           |
| Voltios                                                                                                                                                            | kg Flux / kg Hilo polaridad DC+     |                       |                           |              |                                                   |           |
| 34 V                                                                                                                                                               | 0.8 kg                              |                       |                           |              |                                                   |           |
| 30 V                                                                                                                                                               | 0.6 kg                              |                       |                           |              |                                                   |           |
| 26 V                                                                                                                                                               | 0.5 kg                              |                       |                           |              |                                                   |           |
| 38 V                                                                                                                                                               | 1.0 kg                              |                       |                           |              |                                                   |           |
| Condición : Dimension 4.0 mm , Amperios 580 A , Velocidad de desplazamiento 33 m/h                                                                                 |                                     |                       |                           |              |                                                   |           |
|                                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| Clasificaciones                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| Hilo                                                                                                                                                               | AWS según EN (Euro Norma)           |                       |                           |              |                                                   |           |
| OK Autrod 308L                                                                                                                                                     | A5.9:ER308L/ 14343-A:S 19 9 L       |                       |                           |              |                                                   |           |
|                                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| 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. |                                     |                       |                           |              |                                                   |           |
|                                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| % Análisis metal depositado (valores típicos)                                                                                                                      |                                     |                       |                           |              |                                                   |           |
| C                                                                                                                                                                  | Mn                                  | Si                    | Ni                        | Cr           | N                                                 | FN WRC-92 |
| OK Autrod 308L Current: DC+, 420A, 27V                                                                                                                             |                                     |                       |                           |              |                                                   |           |
| <0.03                                                                                                                                                              | 1.4                                 | 0.6                   | 11.0                      | 20.0         | 0.06                                              | 5         |
|                                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| % Composición hilo (valores típicos)                                                                                                                               |                                     |                       |                           |              |                                                   |           |
| C                                                                                                                                                                  | Mn                                  | Si                    | Ni                        | Cr           | N                                                 |           |
| OK Autrod 308L                                                                                                                                                     |                                     |                       |                           |              |                                                   |           |
| 0.02                                                                                                                                                               | 1.9                                 | 0.4                   | 9.8                       | 19.8         | 0.05                                              |           |
|                                                                                                                                                                    |                                     |                       |                           |              |                                                   |           |
| Propiedades Mecánicas Típicas                                                                                                                                      |                                     |                       |                           |              |                                                   |           |
| Hilo                                                                                                                                                               | Condición                           | Límite de elasticidad | Resistencia a la tracción | Alargamiento | Ensayo Charpy con ranura en V                     |           |
| OK Autrod 308L                                                                                                                                                     | Como soldado DC+                    | 400 MPa               | 540 MPa                   | 40 %         | 80 J @ -60 °C<br>70 J @ -110 °C<br>50 J @ -196 °C |           |