

OK Flux 10.70 (Low-alloyed steels)

OK Flux 10.70 is an agglomerated, basic flux for submerged arc welding. It is designed for welding joints with high dilution such as I-joints with one run from each side and fillet welds. Due to its high alloying of mainly Mn, it creates a weld metal with good toughness values in these joints. It can be used for single and multi-wire procedures and works equally well on DC and AC. On multi-pass welding the number of passes is limited and the plate thickness should not exceed approx. 25mm. Nonalloyed wires such as OK Autrod 12.10 and OK Autrod 12.20 are the preferred ones to be matched with OK Flux 10.70.