

OK Flux 10.17

Agglomerated fluoride basic flux in combination with a nickel-base wire of the 625-type. OK Flux 10.17 has very good welding characteristics giving a smooth bead appearance and an easy slag removal. The combination is suitable for welding similar base material and for dissimilar joint.

Tekniset tiedot

Luokitukset	EN ISO 14174 : S A FB 2B 57 24 DC
Hitsausvirta	900 A (60 x 0.5 mm strip)
Kuonatyyppi	Aluminate-fluoride-basic, Al ₂ O ₃ -CaF ₂
Seostavuus	Moderately silicon alloying
Tiheys	nom: 1,1 kg/dm ³
Emäksisyys	nom: 2,5

Luokittelut

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

Hyväksynät

Lanka

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

Hitsiaineen Koostumus

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Fe
OK Autrod NiCrMo-3 DC+, 300A, 29V, dia 2,4 mm									
0.01	0.1	0.5	-	-	Bal.	21,5	8.5	-	1
OK Autrod NiCrMo-3									
-	-	-	0.01	0.01	-	-	-	0.08	-
OK Band NiCrMo3 DC+, 850A, 28V, 12cm/min									
0.03	0.1	0.6	-	-	61	19.6	8.0	-	9
OK Band NiCrMo3									
-	-	-	0.01	0.01	-	-	-	-	-

Hitsiaineen Koostumus

Nb+Ta									
OK Autrod NiCrMo-3 DC+, 300A, 29V, dia 2,4 mm									
3.2									
OK Band NiCrMo3 DC+, 850A, 28V, 12cm/min									
2.7									
OK Band NiCrMo3									
2.9									

Langan Koostumus

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
OK Band NiCrMo3							
<0.1	0.3	0.1	58.0	22.0	9.0	2.0	4.0

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Tyypilliset mekaaniset ominaisuudet

Lanka	Tila	Myötöraja	Murtolujuus	Venymä	Charpy V -iskusitkeys
OK Autrod NiCrMo-3	Hitsatussa tilassa HI ~1.0-1.6 kJ/mm DC+	460 MPa	710 MPa	44 %	65 J @ -196 °C