

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.

Specifications

Classifications	EN ISO 14174 : S A AF 2 56 44 Ni DC
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃ -SiO ₂
Alloy Transfer	Nickel alloying
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 2.0

Flux Consumption

Volts	kg Flux / kg Wire DC+
34 V	0.8 kg
30 V	0.6 kg
26 V	0.5 kg
38 V	1.0 kg

Condition : Dimension 4.0 mm , Amps 580 A , Travel Speed 33 m/h

Classifications

Wire	SFA/AWS - EN ISO
OK Autrod 308L	A5.9:ER308L/ 14343-A:S 19 9 L

Approvals

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

Typical Weld Metal Analysis %

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

Typical Wire Composition %

C	Mn	Si	Ni	Cr	N
OK Autrod 308L					
0.02	1.9	0.4	9.8	19.8	0.05

Typical Mechanical Properties

Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 308L	As Welded DC+	400 MPa	540 MPa	40 %	80 J @ -60 °C 70 J @ -110 °C 50 J @ -196 °C