OK Flux 10.05

An agglomerated flux designed for strip cladding on unalloyed or low alloyed steels with high-alloyed Cr or Cr-Ni strips. OK Flux 10.05 is designed for the SAW process delivering good welding characteristics, fine bead appearance and easy slag removal.

Specifications	
Classifications	EN ISO 14174 : S A AAS 2B 56 34 DC
Approvals	NAKS/HAKC : RD 03-613-03
Industry	Petrochemical Process Industry

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	1000 A (60 x 0.5 mm strip)
Slag Type	Acid-aluminium-silicate Al2O3-SiO2-CaF2-MgO
Alloy Transfer	Non alloying
Density	nom: 0.7 kg/dm3
Basicity Index	nom: 1.1

Flux Consumption	
Volts	**kg Flux / kg Wire DC+**
32 V	0.6 kg
28 V	0.5 kg
25 V	0.4 kg

Condition : Dimension 60 x 0.5 mm , Amps 750 A , Travel Speed 7 m/h

Classifications	
Wire	**SFA/AWS - EN ISO**
OK Band 308L	A5.9:EQ308L/ 14343-A:B 19 9 L
OK Band 309LNb	14343-A:B 23 12 L Nb
OK Band 316L	A5.9:EQ316L/ 14343-A:B 19 12 3 L
OK Band 347	A5.9:EQ347/ 14343-A:B 19 9 Nb

Approvals	
Wire	**VdTÜV**
OK Band 316L	•

Typical Wire Composition %
OK Band 308L
OK Band 309LNb
OK Band 316L
OK Band 347

Typical Weld Metal Analysis %
OK Band 308L
OK Band 309LNb
OK Band 316L
OK Band 347