OK Flux 10.66

Agglomerated fluoride-basic flux-wire combination for Submerged Arc Welding. Designed for multi-run welding of creep resistant 1,25% Cr 0,5% Mo alloyed steels, SA-387 Grade 11, SA-182 Grade 11, SA-335 Grade P11 or similar materials when highest toughness values are required also after step cooling treatment. Very low level of impurity elements providing a X-bar max. 10 for temper embrittlement resistant applications. Usually welding is followed by a PWHT. Suitable for refinery, petrochemical and chemical industries, power generation, pressure vessels, etc. Very good slag release, also in narrow gap joints. Low-oxygen weld metal (approx. 300 ppm) with hydrogen contents lower than 5 ml/100 g. Designed for single and multi wire procedures, welds equally well on DC and AC current. Mainly for multi layer welding of unlimited plate thickness.

Specifications	
Classifications	EN ISO 14174 : S A FB 1 55 AC H5
Approvals	CE : EN 13479

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

Diffusible Hydrogen	max 5 ml H/100g weld metal (Redried flux)
Slag Type	Fluoride-basic
Alloy Transfer	No Silicon or Manganese alloying
Density	nom: 1.0 kg/dm³
Basicity Index	nom: 2.3 %

Flux Consumption		
Volts	**kg Flux / kg Wire DC+**	**kg Flux / kg Wire AC**
34 V	1.3 kg	1.2 kg
30 V	1.0 kg	0.9 kg
26 V	0.7 kg	0.6 kg
38 V	1.6 kg	1.4 kg

Condition : Dimension Ø 4.0 mm , Amps 580 A , Travel Speed 55 cm/min

Classifications		
Wire	**SFA/AWS - EN ISO**	**AWS - PWHT**
OK Autrod B2 SC	A5.23:EB2R/ 24598-A:S S CrMo1	A5.23: F8P4-EB2R-B2R

Approvals	
Wire	**CE**
OK Autrod B2 SC	•

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Al**
OK Autrod B2 SC									
0.06	0.85	0.19	0.006	0.005	0.03	1.08	0.44	0.004	0.01

Typical Weld Metal Analysis %									
Cu	**Nb**	**Ti**	**Sb**	**As**	**B**	**Sn**	**Mn+Si**	**Nb+Ti+V**	**P+Sn**
OK Autrod B2 SC									
0.04	0.002	0.008	0.001	0.001	0.0002	0.002	1.04	0.014	0.006

Typical Weld Metal Analysis %		
PE	**J-Factor**	**X-bar**
OK Autrod B2 SC		
2	70	6

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Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Al**
OK Autrod B2 SC									
0.1	0.65	0.12	0.003	0.004	0.06	1.2	0.5	0.005	0.005

Typical Wire Composition %									
Cu	**Nb**	**Ti**	**Sb**	**As**	**B**	**Sn**	**Mn+Si**	**Nb+Ti+V**	**P+Sn**
OK Autrod B2 SC									
0.08	0.004	0.002	0.002	0.003	0.0005	0.002	0.77	0.011	0.006

Typical Wire Composition %	
J-Factor	**X-bar**
OK Autrod B2 SC	
50	5

Typical Mechanical Properties					
Wire	**Condition**	**Yield Strength**	**Tensile Strength**	**Elongation**	**Charpy V-Notch**
OK Autrod B2 SC	PWHT AWS DC+ (1 hour(s))	470 MPa	560 MPa	17 %	40 J @ -40 °C
OK Autrod B2 SC	PWHT AWS AC (22 hour(s))	430 MPa	530 MPa	31 %	250 J @ -30 °C
OK Autrod B2 SC	PWHT AWS AC (2 hour(s))	460 MPa	560 MPa	29 %	200 J @ -30 °C
OK Autrod B2 SC	PWHT AWS DC+ (2 hour(s))	420 MPa	530 MPa	32 %	170 J @ -30 °C
OK Autrod B2 SC	PWHT AWS DC+ (22 hour(s))	400 MPa	515 MPa	32 %	220 J @ -30 °C
OK Autrod B2 SC	PWHT EN ISO AC (1 hour(s))	480 MPa	570 MPa	24 %	220 J @ 20 °C