

OK Flux 10.10

High basic, all mineral, agglomerated flux designed for electro slag strip surfacing. The flux is particularly suitable for strip cladding with stainless strip of the Cr-, Cr-Ni- and Cr-Ni-Mo-steel types, with or without Nb.

Specifications	
Classifications	EN ISO 14174 : ES A FB 2B 56 44 DC
Approvals	NAKS/HAKC : RD 03-613-03

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

Welding Current	1700 A (60 x 0.5 mm strip)
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃
Alloy Transfer	Moderately silicon alloying
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 4.0

Condition : Volts 25 V , kg Flux / kg Wire DC+ 0.5 kg , Amps 1250 A , Travel Speed 9 m/h

Classifications		
Wire	SFA/AWS - EN ISO	AWS - As Welded
OK Band 309L ESW	14343-A:B 22 11 L	-
OK Band 309L Mo ESW	A5.9:EQ309L Mo (Mod)/ 14343-A:B 21 13 3 L	-
OK Band 309L Nb ESW	14343-A:B 22 12 L Nb	A5.39: ESCLAD1-EQ309L(mod)/347
OK Band 430	14343-A:B 17	A5.39: ESCLAD2-EQ430(mod)/430

Approvals	
Wire	VdTÜV
OK Band 309L Nb ESW	•

Typical Wire Composition %									
C	Mn	Si	Ni	Cr	Mo	N	Nb	Ferrite FN	FN WRC-92
OK Band 309L ESW									
0.010	1.8	0.2	11.0	21.1	-	0.05	-	-	15
OK Band 309L Mo ESW									
0.015	1.8	0.2	13.5	20.5	2.9	0.06	-	13	-
OK Band 309L Nb ESW									
0.01	1.74	0.20	11.0	21.14	-	0.04	0.6	-	15
OK Band 430									
0.04	0.66	0.4	-	17.0	-	-	-	-	-

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
OK Band 309L ESW									
0.03	1.2	0.4	0.001	0.002	10.0	19.0	0.2	0.1	0.05
OK Band 309L Mo ESW									
0.02	1.1	0.4	0.001	0.008	12.5	18.0	2.8	0.1	0.04
OK Band 309L Nb ESW									
0.03	1.3	0.5	0.001	0.01	10.0	19.0	0.1	0.1	0.05
OK Band 430									
0.06	0.3	0.6	0.005	0.03	0.2	13.3	0.1	0.2	-

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Typical Weld Metal Analysis %		
Nb	FN WRC-92	O
OK Band 309L ESW		
-	4	0.02
OK Band 309LMo ESW		
-	6	-
OK Band 309LNb ESW		
0.4	4	-