

## OK Flux 10.14

This flux/strip-combination is used for electrosag strip cladding giving low carbon, Mo-alloyed 316L material in the first layer. The Mo increases the resistance to pitting corrosion. The flux properties permit to use higher travel speeds, up to about 30 cm/min, with significantly increased cladding productivity.

### Specifications

<b>Classifications</b>	EN ISO 14174 : ES A FB 2B 56 44 DC
<b>Welding Current</b>	approx. 2500 A
<b>Slag Type</b>	Fluoride basic CaF <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub>
<b>Alloy Transfer</b>	Moderately silicon alloying
<b>Density</b>	nom: 1.0 kg/dm <sup>3</sup>
<b>Basicity Index</b>	nom: 4.4

### Classifications

<b>Wire</b>	<b>SFA/AWS - EN ISO</b>
OK Band 309LMo ESW	A5.9:EQ309LMo (Mod)/ 14343-A:B 21 13 3 L
OK Band 309LNb	14343-A:B 23 12 L Nb

### Approvals

#### Wire

\*Selected production units only. Please contact ESAB for more information. Visit [esab.com](http://esab.com) to download specific flux/wire combination fact sheets for more details.

### Typical Weld Metal Analysis %

OK Band 309LMo ESW
OK Band 309LNb

### Typical Wire Composition %

OK Band 309LMo ESW
OK Band 309LNb