

## OK Flux 10.94

Flusso agglomerato basico, cromo compensante, utilizzabile per la saldatura testa a testa di acciai inossidabili altamente legati al Cr-Ni-Mo quali ad esempio, gli acciai Superduplex.

| Specifiche         |                                                                                   |
|--------------------|-----------------------------------------------------------------------------------|
| Classificazioni    | EN ISO 14174 : S A AF 2 56 64 DC                                                  |
| Tipo di scoria     | Fluoride basic CaF <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> -SiO <sub>2</sub> |
| Trasferimento lega | Chromium compensating                                                             |
| Densit             | nom: 1.0 kg/dm <sup>3</sup>                                                       |
| Indice di basicit  | nom: 1.9                                                                          |

| Consumo di Flusso |                        |
|-------------------|------------------------|
| Volt              | kg flusso/ kg filo DC+ |
| 34 V              | 0.8 kg                 |
| 30 V              | 0.6 kg                 |
| 26 V              | 0.5 kg                 |
| 38 V              | 1.0 kg                 |

Stato : Dimension 4.0 mm , Amp 580 A , Velocit di avanzamento 33 m/h

| Classificazioni |                                   |                           |
|-----------------|-----------------------------------|---------------------------|
| filo            | SFA/AWS - EN ISO                  | AWS-come saldato          |
| OK Autrod 2209  | A5.9:ER2209/ 14343-A:S 22 9 3 N L | -                         |
| OK Autrod 2509  | A5.9:ER2594/ 14343-A:S 25 9 4 N L | A5.39: F120A8-ER2594/2594 |
| OK Autrod 308L  | A5.9:ER308L/ 14343-A:S 19 9 L     | -                         |
| OK Autrod 347   | A5.9:ER347/ 14343-A:S 19 9 Nb     | -                         |

| Approvazioni                                                                                                                                                                                     |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| filo                                                                                                                                                                                             |  |
| *Selected production units only. Please contact ESAB for more information. Visit <a href="http://esab.com">esab.com</a> to download specific flux/wire combination fact sheets for more details. |  |

| analisi tipica del deposito                      |     |      |      |       |     |      |     |      |      |
|--------------------------------------------------|-----|------|------|-------|-----|------|-----|------|------|
| C                                                | Mn  | Si   | S    | P     | Ni  | Cr   | Mo  | Cu   | N    |
| OK Autrod 2209                                   |     |      |      |       |     |      |     |      |      |
| -                                                | -   | -    | 0.01 | 0.02  | -   | -    | -   | 0.1  | -    |
| OK Autrod 2209 Current: DC+, 420A, 27V           |     |      |      |       |     |      |     |      |      |
| 0.01                                             | 1.3 | 0.6  | -    | -     | 8.5 | 23.0 | 3.0 | -    | 0.14 |
| OK Autrod 2509 Current: DC+, 400A, 28V, 48cm/min |     |      |      |       |     |      |     |      |      |
| 0.02                                             | 0.4 | 0.45 | 0.01 | 0.017 | 9.3 | 24.5 | 3.5 | 0.10 | 0.24 |
| OK Autrod 308L                                   |     |      |      |       |     |      |     |      |      |
| -                                                | -   | -    | -    | -     | -   | -    | 0.2 | 0.1  | -    |
| OK Autrod 308L DC+                               |     |      |      |       |     |      |     |      |      |
| 0.02                                             | 1.4 | 0.5  | -    | -     | 9.5 | 20   | -   | -    | -    |
| OK Autrod 347                                    |     |      |      |       |     |      |     |      |      |
| -                                                | -   | -    | -    | -     | -   | -    | -   | -    | -    |
| OK Autrod 347 DC+                                |     |      |      |       |     |      |     |      |      |
| 0.04                                             | 1.0 | 0.5  | -    | -     | 9.6 | 19.6 | -   | -    | -    |

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| analisi tipica del deposito                      |           |        |
|--------------------------------------------------|-----------|--------|
| Nb                                               | FN WRC-92 | W      |
| OK Autrod 2209 Current: DC+, 420A, 27V           |           |        |
| -                                                | 45        | -      |
| OK Autrod 2509 Current: DC+, 400A, 28V, 48cm/min |           |        |
| -                                                | 54        | <0.002 |
| OK Autrod 308L                                   |           |        |
| -                                                | 11        | -      |
| OK Autrod 347                                    |           |        |
| -                                                | 9         | -      |
| OK Autrod 347 DC+                                |           |        |
| 0.5                                              | -         | -      |

| Typical Wire Composition % |     |     |     |      |     |      |     |     |           |
|----------------------------|-----|-----|-----|------|-----|------|-----|-----|-----------|
| C                          | Mn  | Si  | Ni  | Cr   | Mo  | N    | Nb  | PRE | FN WRC-92 |
| OK Autrod 2209             |     |     |     |      |     |      |     |     |           |
| 0.01                       | 1.5 | 0.5 | 8.5 | 22.7 | 3.2 | 0.17 | -   | 35  | 55        |
| OK Autrod 2509             |     |     |     |      |     |      |     |     |           |
| 0.01                       | 0.4 | 0.4 | 9.4 | 25.2 | 3.9 | 0.24 | -   | 42  | 50        |
| OK Autrod 308L             |     |     |     |      |     |      |     |     |           |
| 0.02                       | 1.9 | 0.4 | 9.8 | 19.8 | -   | 0.05 | -   | -   | -         |
| OK Autrod 347              |     |     |     |      |     |      |     |     |           |
| 0.04                       | 1.4 | 0.4 | 9.5 | 19.2 | -   | 0.05 | 0.6 | -   | 7         |

| Proprietà meccaniche tipiche |                  |                             |                          |              |                                                                    |
|------------------------------|------------------|-----------------------------|--------------------------|--------------|--------------------------------------------------------------------|
| filo                         | Stato            | Resistenza allo snervamento | Resistenza alla trazione | Allungamento | Intaglio a V Charpy                                                |
| OK Autrod 2209               | Come saldato DC+ | 630 MPa                     | 780 MPa                  | 30 %         | 60 J @ -40 °C<br>42 J @ -60 °C                                     |
| OK Autrod 2509               | Come saldato DC+ | 680 MPa                     | 870 MPa                  | 25 %         | 70 J @ 20 °C<br>50 J @ -60 °C                                      |
| OK Autrod 308L               | Come saldato     | 400 MPa                     | 560 MPa                  | 40 %         | 85 J @ 20 °C<br>70 J @ -40 °C<br>60 J @ -60 °C                     |
| OK Autrod 347                | Come saldato     | 455 MPa                     | 620 MPa                  | 35 %         | 100 J @ 20 °C<br>70 J @ -60 °C<br>50 J @ -110 °C<br>30 J @ -196 °C |