

## OK Flux 10.11

L OK Flux 10.11 ? un flusso altamente basico adatto per placcature in elettroscoria. Il flusso ? a bassa viscosit  ed ? indicato per placcature con nastri a base nichel /nichel cobalto grazie alla sue ottime propriet  di fusione anche con elevate velocit  di avanzamento.

### Specifiche

|                       |                                    |
|-----------------------|------------------------------------|
| Classificazioni       | EN ISO 14174 : ES A FB 2B 56 44 DC |
| Corrente di saldatura | approx. 2500 (90 x 0.5 mm strip)   |
| Tipo di scoria        | Fluoride basic CaF2-Al2O3          |
| Trasferimento lega    | Moderately silicon alloying        |
| Densit                | nom: 1.0 kg/dm3                    |
| Indice di basicit     | nom: 5.4                           |

### Classificazioni

|                 |                                                   |
|-----------------|---------------------------------------------------|
| filo            | SFA/AWS - EN ISO                                  |
| OK Band NiCrMo3 | A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)   |
| OK Band NiFeCr1 | A5.14:EQNiFeCr-1/ 18274:B Ni 8065 (NiFe30Cr21Mo3) |

### 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  | Al   | Cu   |
|---------------------------------------|------|------|-------|-------|------|------|-----|------|------|
| OK Band NiCrMo3                       |      |      |       |       |      |      |     |      |      |
| 0.04                                  | 0.08 | 0.50 | -     | -     | Bal. | 20.1 | 8.1 | -    | 0.01 |
| OK Band NiFeCr1                       |      |      |       |       |      |      |     |      |      |
| -                                     | -    | -    | 0.001 | 0.015 | -    | -    | -   | 0.03 | -    |
| OK Band NiFeCr1 1250A, 24V, 18cm/min. |      |      |       |       |      |      |     |      |      |
| 0.018                                 | 0.5  | 0.85 | -     | -     | 38.5 | 20.0 | 2.9 | -    | 1.8  |

### analisi tipica del deposito

| Ti                                    | Fe   | Nb+Ta |
|---------------------------------------|------|-------|
| OK Band NiCrMo3                       |      |       |
| -                                     | 6.0  | 2.8   |
| OK Band NiFeCr1 1250A, 24V, 18cm/min. |      |       |
| 0.1                                   | 31.0 | -     |

### Typical Wire Composition %

| C               | Mn   | Si  | Ni   | Cr   | Mo  | Cu  | Ti  | Fe    | Nb+Ta |
|-----------------|------|-----|------|------|-----|-----|-----|-------|-------|
| OK Band NiCrMo3 |      |     |      |      |     |     |     |       |       |
| <0.1            | 0.3  | 0.1 | 58.0 | 22.0 | 9.0 | -   | -   | 2.0   | 4.0   |
| OK Band NiFeCr1 |      |     |      |      |     |     |     |       |       |
| 0.01            | 0.78 | 0.3 | 42.5 | 22.5 | 3.0 | 2.2 | 1.0 | >22.0 | -     |