

OK Flux 10.63

Agglomerated fluoride-basic flux-wire combination for Submerged Arc Welding. Designed for multi-run welding of creep resistant 2,25% Cr, 1% Mo alloyed steels when highest toughness values are required also after step cooling treatment. Very low level of impurities and thus exceptionally clean weld metal. X-factor max. 15. Mainly for petrochemical and chemical industries, power generation, pressure vessels, etc. Suitable for narrow gap welding. Low-oxygen weld metal (approx. 300 ppm) with hydrogen contents lower than 5 ml/100 g. Operates optimally at the lower end of the voltage range. Designed for single and multi wire procedures, welds equally well on DC and AC current. Mainly for multi layer welding of unlimited plate thickness.

Especificaciones	
Clasificaciones	EN ISO 14174 : S A FB 1 55 AC H5
Aprobaciones	NAKS/HAKC : RD 03-613-03

Las aprobaciones se basan en la ubicación de la fábrica. Póngase en contacto con ESAB para obtener más información.

Hidrógeno Difusible	max 5 ml H/100g weld metal (Redried flux)
Tamaño de escoria	Fluoride-basic
Transferencia de aleación	No Silicon or Manganese alloying
Densidad	nom: 1.1 kg/dm3
Indice de Basicidad	nom: 3.0

Consumo de flux		
Tensión	Kg Flux / Kg Alambre dc	Kg Flux / Kg Alambre 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

Condición : Dimension Ø 4.0 mm , Corriente 580 A , Velocidad de desplazamiento 55 cm/min

Clasificaciones		
Alambre	AWS/EN	AWS -Tratamiento térmico pos soldadura
OK Autrod 13.10 SC	A5.23:EB2R/ 24598-A:S S CrMo1	A5.23: F8P4-EB2R-B2R
OK Autrod 13.20 SC	A5.23:EB3R/ 24598-A:S S CrMo2	A5.23: F8P8-EB3R-B3R

Aprobaciones	
Alambre	
*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.	

% típico de análisis de metal de soldadura								
C	Mn	Si	Cr	Mo	Mn+Si	PE	J-Factor	X-bar
OK Autrod 13.10 SC DC+, 485A, 30V								
0.075	0.8	0.25	1.1	0.5	-	-	-	<= 15
OK Autrod 13.10 SC AC, 565A, 30V								
0.08	0.85	0.20	1.15	0.5	-	-	-	<= 15
OK Autrod 13.10 SC								
-	-	-	-	-	1.1	2.1	100	-
OK Autrod 13.20 SC DC+, 580A, 29V								
0.07	0.60	0.20	2.1	1.0	-	-	-	<= 15
OK Autrod 13.20 SC AC, 580A, 29V								
0.08	0.60	0.20	2.1	1.0	-	-	-	<= 15

% típico de composición de alambre					
C	Mn	Si	Cr	Mo	X-bar
OK Autrod 13.10 SC					

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% típico de composición de alambre

C	Mn	Si	Cr	Mo	X-bar
0.10	0.83	0.12	1.21	0.49	-
OK Autrod 13.20 SC					
0.11	0.66	0.15	2.33	0.95	11