

OK Flux 282

OK Flux 282 is an active, bonded flux designed for high speed, single pass welding of carbon steel sheet. Butt, lap, and fillet welds are well washed and free from undercut even at speeds up to 120 IPM (305 cm/min). It is primarily used with DC single and parallel wire systems at currents up to 1300 amps. OK Flux 282 is recommended for making high speed welds in metallic building beams, spiral pipe, storage tanks, and rail cars.

Especificaciones	
Clasificaciones	ASME SFA 5.17 AWS A5.17 : F7AZ-EM12K AWS A5.17 : F7AZ-EM13K
Sector	Vagones de trenes Construcción de tubos Fabricación de tanques y vasos Fabricación de vigas metálicas

Tamaño de escoria	ZS (Zirconium-Silicate)
Transferencia de aleación	Very high silicon alloying and slightly manganese alloying
Densidad	nom: 1.33 kg/dm3
Indice de Basicidad	nom: 0.3

Clasificaciones	
Alambre	AWS/EN
Spoolarc 29S	A5.17:EM13K

Aprobaciones	
Alambre	CWB
Spoolarc 29S	•
Spoolarc 81	•

% típico de composición de alambre					
C	Mn	Si	S	P	Cu
Spoolarc 29S					
0.08	1.15	0.5	0.006	0.013	0.06
Spoolarc 81					
0.09	0.95	0.26	0.01	0.01	-

% típico de análisis de metal de soldadura									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
Spoolarc 29S									
0.09	1.15	1.00	0.01	0.03	0.047	0.063	0.019	0.008	0.020
Spoolarc 81									
0.09	1.24	0.80	0.02	0.03	-	-	-	-	-
Spoolarc 81 As Welded									
0.05	1.14	0.67	0.013	0.040	0.05	0.07	0.02	-	-

% típico de análisis de metal de soldadura			
Cu	Nb	Ti	Co
Spoolarc 29S			
0.143	0.005	0.020	0.007
Spoolarc 81 As Welded			
0.130	-	-	-