OK Flux 10.10

High basic, all mineral, agglomerated flux designed for electro slag strip surfacing. The flux is particularly suitable for strip cladding with stainless strip of the Cr-, Cr-Ni- and Cr-Ni-Mo-steel types, with or without Nb.

Specifications	
Classifications	EN ISO 14174 : ES A FB 2B 56 44 DC
Approvals	NAKS/HAKC : RD 03-613-03

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	1700 A (60 x 0.5 mm strip)
Slag Type	Fluoride basic CaF2-Al2O3
Alloy Transfer	Moderately silicon alloying
Density	nom: 1.0 kg/dm3
Basicity Index	nom: 4.0

Condition : Volts 25 V , kg Flux / kg Wire DC+ 0.5 kg , Amps 1250 A , Travel Speed 9 m/h

Classifications		
Wire	**SFA/AWS - EN ISO**	**AWS - As Welded**
OK Band 309L ESW	14343-A:B 22 11 L	-
OK Band 309LMo ESW	A5.9:EQ309LMo (Mod)/ 14343-A:B 21 13 3 L	-
OK Band 309LNb ESW	14343-A:B 22 12 L Nb	A5.39: ESCLAD1-EQ309L(mod)/347
OK Band 430	14343-A:B 17	A5.39: ESCLAD2-EQ430(mod)/430

Approvals	
Wire	**VdTÜV**
OK Band 309LNb ESW	•

Typical Wire Composition %
OK Band 309L ESW
OK Band 309LMo ESW
OK Band 309LNb ESW
OK Band 430

Typical Weld Metal Analysis %
OK Band 309L ESW
OK Band 309LMo ESW
OK Band 309LNb ESW
OK Band 430