

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.

Specifications

Classifications	EN ISO 14174 : S A FB 1 55 AC H5
Approvals	NAKS/HAKC : RD 03-613-03

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

Diffusible Hydrogen	max 5 ml H/100g weld metal (Redried flux)
Slag Type	Fluoride-basic
Alloy Transfer	No Silicon or Manganese alloying
Density	nom: 1.1 kg/dm ³
Basicity Index	nom: 3.0

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire 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

Condition : Dimension Ø 4.0 mm , Amps 580 A , Travel Speed 55 cm/min

Classifications

Wire	SFA/AWS - EN ISO	AWS - PWHT
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

Approvals

Wire

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

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	Mn+Si	PE	J-Factor	X-bar
OK Autrod 13.10 SC								
-	-	-	-	-	1.1	2.1	100	-
OK Autrod 13.10 SC AC, 565A, 30V								
0.08	0.85	0.20	1.15	0.5	-	-	-	<= 15
OK Autrod 13.10 SC DC+, 485A, 30V								
0.075	0.8	0.25	1.1	0.5	-	-	-	<= 15
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

Typical Wire Composition %

C	Mn	Si	Cr	Mo	X-bar
OK Autrod 13.10 SC					

OK Flux 10.63

Typical Wire Composition %

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