

OK Flux 10.11

Very high basic agglomerated flux for electro slag strip cladding. The flux has a low viscosity and is suitable for cladding with Ni base, Co and fully austenitic alloys due to its good wetting behaviour. Also suitable for welding with higher travel speeds.

Specifications

Classifications	EN ISO 14174 : ES A FB 2B 56 44 DC
Welding Current	approx. 2500 (90 x 0.5 mm strip)
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃
Alloy Transfer	Moderately silicon alloying
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 5.4

Classifications

Wire	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)

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	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 1250A, 24V, 18cm/min.									
0.018	0.5	0.85	-	-	38.5	20.0	2.9	-	1.8
OK Band NiFeCr1									
-	-	-	0.001	0.015	-	-	-	0.03	-

Typical Weld Metal Analysis %

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	-