

OK Flux 10.76

Agglomerated aluminate-basic flux for Submerged Arc Welding particular for applications with high dilution from the base material, e.g. butt welds with one run from each side or fillet welds. Good impact properties due to high alloying of Mn and Si. Especially designed to be used with OK Autrod 12.10. Mainly for shipbuilding, also for pressure vessels, transport industries, general constructions, etc. Suitable for single and multi wire procedures, for DC and AC welding. Intended for a limited number of passes and plate thickness up to about 25 mm.

Specifications

Classifications	EN ISO 14174 : S A AB 1 89 AC
Approvals	CE : EN 13479 DB : 51.039.11

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

Slag Type	Aluminate-basic
Alloy Transfer	High Silicon and very high Manganese alloying
Density	nom: 1.2 kg/dm ³
Basicity Index	nom: 1.5
Grain Size (met)	0.2-1.6 mm (10x65 mesh)

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	EN - As Welded	AWS - As Welded	AWS - PWHT
OK Autrod 12.10	A5.17:EL12/ 14171-A:S1	14171-A: S 42 3 AB S1	A5.17: F7A4-EL12	A5.17: F7P4-EL12

Approvals

Wire	ABS	BV	CE	DB	DNV	GL	LR	PRS	RS
OK Autrod 12.10	•	•	•	•	•	•	•	•	•

Typical Weld Metal Analysis %

C	Mn	Si
OK Autrod 12.10 DC+ , 580A, 29V		
0.06	1.9	0.5
OK Autrod 12.10 AC , 580A, 29V		
0.08	1.8	0.5

Typical Mechanical Properties

Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.10	As Welded EN AC	470 MPa	550 MPa	25 %	110 J @ 0 °C 80 J @ -20 °C 60 J @ -30 °C 110 J @ 0 °C 80 J @ -20 °C 60 J @ -30 °C

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Typical Mechanical Properties

Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.10	As Welded AWS DC+	450 MPa	540 MPa	25 %	100 J @ 0 °C 70 J @ -20 °C 55 J @ -30 °C 45 J @ -40 °C