

OK Flux 10.92

This flux/wire combination is designed for welding of austenitic chromium nickel alloys of the same or similar types. The 19/12/3 type of weld metal increases corrosion resistance compared to an 18/8 deposit.

Specifications

Classifications	EN ISO 14174 : S A CS 2 57 53 DC
Approvals	NAKS/HAKC : RD 03-613-03

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

Welding Current	1200 A
Slag Type	Calcium silicate SiO ₂ -MgO-Al ₂ O ₃ -(CaF ₂)
Alloy Transfer	Chromium compensating
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 1.0

Flux Consumption

Volts	kg Flux / kg Wire DC+
34 V	0.7 kg
30 V	0.55 kg
26 V	0.4 kg
38 V	0.9 kg

Conditions : Dimension 4.0 mm , Amps 580 A , Travel Speed 33 m/h

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
OK Autrod 16.97	14343-A:S 18 8 Mn	-
OK Autrod 308L	A5.9:ER308L/ 14343-A:S 19 9 L	-
OK Autrod 309L	A5.9:ER309L/ 14343-A:S 23 12 L	A5.39: F85A4-ER309L/309L
OK Autrod 316L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F80A10-ER316L/316L
OK Autrod 318	A5.9:ER318/ 14343-A:S 19 12 3 Nb	-
OK Autrod 347	A5.9:ER347/ 14343-A:S 19 9 Nb	-

Approvals

Wire	VdTÜV	BV
OK Autrod 308L	•	-
OK Autrod 316L	•	•
OK Autrod 318	•	-
OK Autrod 347	•	-

Typical Weld Metal Analysis %

OK Autrod 16.97
OK Autrod 308L Current: DC+, 420A, 27V
OK Autrod 309L
OK Autrod 316L
OK Autrod 318
OK Autrod 347 Current: DC+, 420 A, 27 V

Typical Wire Composition %

OK Autrod 16.97
OK Autrod 308L

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Typical Wire Composition %

OK Autrod 309L
OK Autrod 316L
OK Autrod 318
OK Autrod 347

Typical Mechanical Properties

Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 16.97	As Welded DC+	450 MPa	630 MPa	42 %	60 J @ 20 °C 55 J @ -20 °C 45 J @ -60 °C
OK Autrod 308L	As Welded DC+	365 MPa	580 MPa	38 %	60 J @ -60 °C 50 J @ -110 °C
OK Autrod 309L	As Welded DC+	440 MPa	600 MPa	30 %	55 J @ -20 °C 50 J @ -40 °C
OK Autrod 316L	As Welded DC+	415 MPa	570 MPa	32 %	55 J @ -70 °C
OK Autrod 318	As Welded	440 MPa	600 MPa	42 %	100 J @ 20 °C 90 J @ -60 °C 40 J @ -110 °C
OK Autrod 347	As Welded DC+	470 MPa	640 MPa	35 %	65 J @ 20 °C 55 J @ -60 °C 40 J @ -110 °C