# OK Flux 10.17

Agglomerated fluoride basic flux in combination with a nickel-base wire of the 625-type. OK Flux 10.17 has very good welding characteristics giving a smooth bead appearance and an easy slag removal. The combination is suitable for welding similar base material and for dissimilar joint.

| Specifications | |
|---|---|
| **Classifications** | EN ISO 14174 : S A FB 2B 57 24 DC |

| | |
|---|---|
| **Welding Current** | 900 A (60 x 0.5 mm strip) |
| **Slag Type** | Aluminate-fluoride-basic, Al2O3-CaF2 |
| **Alloy Transfer** | Moderately silicon alloying |
| **Density** | nom: 1,1 kg/dm³ |
| **Basicity Index** | nom: 2,5 |

| Classifications | |
|---|---|
| **Wire** | **AWS/EN** |
| OK Autrod NiCrMo-3 | A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr22Mo9Nb) |
| OK Band NiCrMo3 | A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb) |

| Approvals |
|---|
| **Combined with 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** | **Cu** | **Fe** |
| **OK Autrod NiCrMo-3** | | | | | | | | | |
| - | - | - | 0.01 | 0.01 | - | - | - | 0.08 | - |
| **OK Autrod NiCrMo-3 DC+, 300A, 29V, dia 2,4 mm** | | | | | | | | | |
| 0.01 | 0.1 | 0.5 | - | - | Bal. | 21,5 | 8.5 | - | 1 |
| **OK Band NiCrMo3** | | | | | | | | | |
| - | - | - | 0.01 | 0.01 | - | - | - | - | - |
| **OK Band NiCrMo3 DC+, 850A, 28V, 12cm/min** | | | | | | | | | |
| 0.03 | 0.1 | 0.6 | - | - | 61 | 19.6 | 8.0 | - | 9 |

| Typical Weld Metal Analysis % |
|---|
| **Nb+Ta** |
| **OK Autrod NiCrMo-3 DC+, 300A, 29V, dia 2,4 mm** |
| 3.2 |
| **OK Band NiCrMo3** |
| 2.9 |
| **OK Band NiCrMo3 DC+, 850A, 28V, 12cm/min** |
| 2.7 |

| Typical Wire Composition % | | | | | | | |
|---|---|---|---|---|---|---|---|
| **C** | **Mn** | **Si** | **Ni** | **Cr** | **Mo** | **Fe** | **Nb+Ta** |
| **OK Autrod NiCrMo-3** | | | | | | | |
| 0.02 | 0.04 | 0.06 | Bal | 22.7 | 8.6 | 0.3 | 3.5 |
| **OK Band NiCrMo3** | | | | | | | |
| <0.1 | 0.3 | 0.1 | 58.0 | 22.0 | 9.0 | 2.0 | 4.0 |

# OK Flux 10.17

| Typical Mechanical Properties | | | | | |
|---|---|---|---|---|---|
| **Combined with Wire** | **Condition** | **Yield Strength** | **Tensile Strength** | **Elongation** | **Charpy V-Notch** |
| OK Autrod NiCrMo-3 | As Welded HI ~1.0-1.6 kJ/mm DC+ | 460 MPa ( 67 ksi ) | 710 MPa ( 103 ksi ) | 44 % | 65 J @ -196 °C ( 48 ft-lb @ -320.8 °F ) |