

OK Flux 282

OK Flux 282 is an active, bonded flux designed for high speed, single pass welding of carbon steel sheet. Butt, lap, and fillet welds are well washed and free from undercut even at speeds up to 120 IPM (305 cm/min). It is primarily used with DC single and parallel wire systems at currents up to 1300 amps. OK Flux 282 is recommended for making high speed welds in metallic building beams, spiral pipe, storage tanks, and rail cars. *Single pass application only. Any mechanical property and undiluted weld chemistry listed are for information only.

| Specifications | |
|-----------------|--|
| Classifications | ASME SFA 5.17 AWS A5.17 : F7AZ-EM12K AWS A5.17 : F7AZ-EM13K |
| Industry | Metal Beam Fabrication Pipe Construction Tank and Vessel Fabrication Railcars |

| | |
|----------------|--|
| Slag Type | ZS (Zirconium-Silicate) |
| Alloy Transfer | Very high silicon alloying and slightly manganese alloying |
| Density | nom: 1.33 kg/dm ³ |
| Basicity Index | nom: 0.3 |

| Classifications | |
|-----------------|-------------|
| Wire | AWS/EN |
| Spoolarc 29S | A5.17:EM13K |

| Approvals | |
|--------------------|-----|
| Combined with Wire | CWB |
| Spoolarc 29S | • |
| Spoolarc 81 | • |

| Typical Wire Composition % | | | | | |
|----------------------------|------|------|-------|-------|------|
| C | Mn | Si | S | P | Cu |
| Spoolarc 29S | | | | | |
| 0.08 | 1.15 | 0.5 | 0.006 | 0.013 | 0.06 |
| Spoolarc 81 | | | | | |
| 0.09 | 0.95 | 0.26 | 0.01 | 0.01 | - |

| Typical Weld Metal Analysis % | | | | | | | | | |
|-------------------------------|------|------|-------|-------|-------|-------|-------|-------|-------|
| C | Mn | Si | S | P | Ni | Cr | Mo | V | Al |
| Spoolarc 29S | | | | | | | | | |
| 0.09 | 1.15 | 1.00 | 0.01 | 0.03 | 0.047 | 0.063 | 0.019 | 0.008 | 0.020 |
| Spoolarc 81 As Welded | | | | | | | | | |
| 0.05 | 1.14 | 0.67 | 0.013 | 0.040 | 0.05 | 0.07 | 0.02 | - | - |
| Spoolarc 81 | | | | | | | | | |
| 0.09 | 1.24 | 0.80 | 0.02 | 0.03 | - | - | - | - | - |

| Typical Weld Metal Analysis % | | | |
|-------------------------------|-------|-------|-------|
| Cu | Nb | Ti | Co |
| Spoolarc 29S | | | |
| 0.143 | 0.005 | 0.020 | 0.007 |
| Spoolarc 81 As Welded | | | |

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Typical Weld Metal Analysis %

| Cu | Nb | Ti | Co |
|-------|----|----|----|
| 0.130 | - | - | - |