

OK Flux 350

Specifications

Classifications	ASME SFA 5.17 AWS A5.17 : F7A2-EL12 AWS A5.17 : F7A2-EM12K AWS A5.17 : F7A2-EM13K
Approvals	CWB : CSA W48 F49A3-EM12K-H8
Industry	Pressure Vessels Ship/Barge Building Tank and Vessel Fabrication Railcars

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

Slag Type	MS (Manganese-Silicate)
Alloy Transfer	Very high silicon alloying and high manganese alloying
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 0.9

Classifications

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

Approvals

Combined with Wire	CWB
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	Cu
Spoolarc 29S As Welded								
0.04	2.04	1.05	0.009	0.029	0.05	0.040	0.01	0.019
Spoolarc 29S								
0.04	1.90	0.90	0.02	0.02	-	-	-	-
Spoolarc 81 As Welded								
0.06	1.72	1.02	0.019	0.021	0.07	0.06	0.02	0.160
Spoolarc 81								
0.04	1.80	0.70	0.01	0.02	-	-	-	-

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Spoolarc 29S	As Welded	542 MPa (79 ksi)	649 MPa (94 ksi)	27 %	36 J @ -29 °C (27 ft-lb @ -20.2 °F)

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Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Spoolarc 81	As Welded	493 MPa (72 ksi)	610 MPa (88 ksi)	28 %	37 J @ -29 °C (27 ft-lb @ -20.2 °F)