

## OK Flux 10.62

Agglomerated fluoride-basic flux for Submerged Arc Welding. Primarily for multi-run welding. For highest demands on impact properties, low temperature toughness, strength and CTOD-values. Especially suitable for narrow gap welding due to good slag detachability and smooth side-wall blending. The Advanced Slag Release version improves weldability with excellent slag detachability, even better side wall wetting and stronger grains which improve weld quality due to flux grain size consistency also after multiple recycling cycles. All other attributes unchanged. For Offshore constructions, pressure vessels, power generation, shipbuilding, pipe mills, civil constructions, transport industries, etc. Produces weld metals with hydrogen contents maximum 5 ml/100 g, in BlockPac (moisture protection) maximum 4 ml/100g. Operates optimally at the lower end of the voltage range. Designed for single and multi wire procedures, for butt and fillet welds. Works equally well on DC and AC current. Single layer and multi layer welding of unlimited plate thickness.

### Specifications

|                        |                                                                    |
|------------------------|--------------------------------------------------------------------|
| <b>Classifications</b> | EN ISO 14174 : S A FB 1 55 AC H5                                   |
|                        | EN ISO 14174 : S A FB 1 55 AC H4 only BlockPac/moisture-protection |
| <b>Approvals</b>       | CE : EN 13479                                                      |
|                        | DB : 51.039.07                                                     |
|                        | UKCA : EN 13479                                                    |

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

|                            |                                                                                          |
|----------------------------|------------------------------------------------------------------------------------------|
| <b>Diffusible Hydrogen</b> | max 5 ml/100g weld metal (Redried flux); max 4 ml/100g in BlockPac (moisture protection) |
| <b>Slag Type</b>           | Fluoride-basic                                                                           |
| <b>Alloy Transfer</b>      | No Silicon or Manganese alloying                                                         |
| <b>Density</b>             | nom: 1.1 kg/dm <sup>3</sup>                                                              |
| <b>Basicity Index</b>      | nom: 3.2                                                                                 |

### 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 |
|-------------|------------------|
| Spoolarc 83 | A5.23:EA3K       |
| Spoolarc 95 | A5.23:EM2        |

### Approvals

| Wire        | ABS | CWB |
|-------------|-----|-----|
| Spoolarc 81 | •   | •   |

### Typical Wire Composition %

|               |
|---------------|
| Spoolarc 71   |
| Spoolarc 81   |
| Spoolarc 83   |
| Spoolarc 86   |
| Spoolarc 95   |
| Spoolarc ENi4 |

### Typical Weld Metal Analysis %

|                                            |
|--------------------------------------------|
| Spoolarc 71 As Welded                      |
| Spoolarc 71 Stress Relieved 1 hr. @ 1150°F |

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### Typical Weld Metal Analysis %

Spoolarc 81

Spoolarc 83 As Welded

Spoolarc 83 Stress Relieved 1 hr. @ 1150°F

Spoolarc 86 Stress Relieved 1 hr. @ 1150°F

Spoolarc 95 As Welded

Spoolarc ENi4 As Welded

Spoolarc ENi4 Stress Relieved 1 hr. @ 1150°F

### Typical Mechanical Properties

| Wire          | Condition | Yield Strength | Tensile Strength | Elongation | Charpy V-Notch                   |
|---------------|-----------|----------------|------------------|------------|----------------------------------|
| Spoolarc 71   | As Welded | 511 MPa        | 590 MPa          | 28 %       | 126 J @ -51 °C                   |
| Spoolarc 81   | As Welded | 442 MPa        | 527 MPa          | 31 %       | 80 J @ -62 °C                    |
| Spoolarc 83   | As Welded | 692 MPa        | 746 MPa          | 24 %       | 62 J @ -51 °C                    |
| Spoolarc 95   | As Welded | 686 MPa        | 758 MPa          | 25 %       | 101 J @ -51 °C                   |
| Spoolarc ENi4 | As Welded | 532 MPa        | 618 MPa          | 27 %       | 145 J @ -62 °C<br>109 J @ -73 °C |