



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.05

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Paolo Torchiana	Reg no EN006548	Cancelling EN006018	Reg date 2014-09-29	Page 1 (1)
-------------------------------	------------------------------	--------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

Slag type amended.

GENERAL

An agglomerated flux designed for strip cladding on unalloyed or low alloyed steels with high-alloyed Cr or Cr-Ni strips.

CLASSIFICATIONS Flux

EN ISO 14174 S A AAS 2B 56 34 DC

APPROVALS

NAKS/HAKC RD 03-613-03

APPROVAL COMMENT

All others: See Flux-Strip combinations

SLAG TYPE

Acid-aluminium-silicate Al₂O₃-SiO₂-CaF₂-MgO

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃ +MnO	35	
CaF ₂	25	
CaO+MgO	15	
SiO ₂ +TiO ₂	25	

Other properties:

Alloy Transfer	Non alloying
Basicity (Boniszewski)	nom: 1.1
Bulk Density	nom: 0.7 kg/dm ³
Max Amperage Strip	1000 A (60 x 0.5 mm strip)

FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
25	0.4	
28	0.5	
32	0.6	

Current (A):	750
Travel Speed (m/h):	7
Dimension (mm):	60 x 0.5

OTHER DATA

The flux is delivered in plastic-lined paperbags containing 20 kg.