



Product Data Sheet

ES 'Electro-slag welding'

OK Flux 10.14

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REASON FOR ISSUE

EN ISO 14174 classification and approval statement added.

GENERAL

High basic agglomerated flux for electro slag strip cladding.

The flux is suitable for cladding with austenitic Cr-, CrNi- and CrNiMo-strips at higher travel speeds.

CLASSIFICATIONS Flux

EN ISO 14174 ES A FB 2B 56 44 DC

APPROVALS

Not applicable

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃	20	
CaF ₂	70	
SiO ₂ +MgO	10	

Other properties:

Alloy Transfer	Moderately silicon alloying
Basicity (Boniszewski)	nom: 4.4
Bulk Density	nom: 1.0 kg/dm ³
Max Amperage Strip	approx. 2500

FLUX CONSUMPTION

	(kg Flux / kg Wire/Strip)	
Arc Voltage	DC+	AC
25	0.5	

OTHER DATA

The flux is delivered in plastic-lined paperbags containing 25 kg.