Product Data Sheet OK Flux 10.16

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REASON FOR ISSUE

EN 760 replaced by EN ISO 14174, Approval statement modified.

GENERAL

High basic, all mineral, agglomerated flux designed for welding nickel and nickel based alloys. The flux is particularly suitable for strip cladding with Ni-based strip.

The silicon transfer from the flux to the weld metal is strongly reduced by the well balanced flux composition and thus minimizing the risk for hot cracking in welding Ni-based alloys.

CLASSIFICATIONS Flux

EN ISO 14174	S A FB 2 55 43 DC

APPROVAL COMMENT

See Flux-Wire/Strip combinations

SLAG TYPE

Fluoride basic CaF2-Al2O3-(TiO2)-(MnO)

CHEMICAL COMPOSITION

	Flux (%)
	Nom
Al2O3+MnO	30
CaF2	50
SiO2+TiO2	15

Other properties:

Alloy Transfer	Moderately manganese and silicon alloying
Basicity (Boniszewski)	nom: 2.4
Bulk Density	nom: 1.2 kg/dm3
Max Amperage Strip	900 A (60 x 0.5 mm strip)

OTHER DATA

* When butt welding with Ni-based wires, reverse polarity is preferably used in order to minimize the dilution from the base metal and thus to diminish the risk for hot cracking.

* Recommended data for multirun welding:

Wire diameter = 1.6 mm: DC-, 200-300 A, 28-32 V, 20-25 m/h

Wire diameter = 2.4 mm: DC-, 275-375 A, 30-34 V, 25-30 m/h

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