



# Product Data Sheet

S 'Submerged arc welding'

## OK Flux 10.18

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### REASON FOR ISSUE

EN 760 replaced by EN ISO 14174.

### GENERAL

OK Flux 10.18 is an agglomerated flux designed for cladding with Monel strip. The flux is particularly suitable for strip cladding with NiCu7-strip giving shiny bead finish and smooth overlaps.

### CLASSIFICATIONS Flux

EN ISO 14174      S A CS 2B 58 13 DC

### APPROVALS

Not applicable

### SLAG TYPE

Calcium silicate SiO<sub>2</sub>-CaO-CaF<sub>2</sub>-(MnO-Al<sub>2</sub>O<sub>3</sub>)

### CHEMICAL COMPOSITION

Flux (%)	
	Nom
Al <sub>2</sub> O <sub>3</sub> +MnO	10
CaF <sub>2</sub>	20
CaO+MgO	20
SiO <sub>2</sub> +TiO <sub>2</sub>	50

### Other properties:

<b>Alloy Transfer</b>	Moderately silicon alloying
<b>Basicity (Boniszewski)</b>	nom: 1.0
<b>Max Amperage Strip</b>	1000 A

### REDRYING

300 °C, 2 h

### OTHER DATA

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

\* Flux consumption when strip cladding:

Strip size: 60 x 0.5 mm

DC+, 800 A, 28-29 V, 12cm/min

Flux consumption = 0.7 kg flux / kg strip.