



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.33

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REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. Approval statement added.

GENERAL

Agglomerated fluoride-basic flux designed primarily for surfacing of continuous casting rollers, using cored wires with single- or twin-arc technique with oscillating procedure. The flux has excellent slag removal and can tolerate high interpass temperatures.

CLASSIFICATIONS Flux

EN ISO 14174 S A FB 2 56 53 DC

APPROVALS

Not applicable

SLAG TYPE

Fluoride-basic MgO-CaF₂-Al₂O₃-SiO₂

CHEMICAL COMPOSITION

	Flux (%)
	Nom
Al ₂ O ₃ +MnO	15
CaF ₂	25
CaO+MgO	35
SiO ₂ +TiO ₂	20

Other properties:

Alloy Transfer	Non-alloying
Basicity (Boniszewski)	nom: 2.9 %
Bulk Density	nom: 1.1 %
Moisture 1000 °C	nom: 0.03 %

OTHER DATA

Typical weld metal chemistry, using OK Tubrodur 15.72S:

C 0,05 %

Si 0,8 %

Mn 1,0 %

Cr 13,0 %

Ni 4,3 %

Mo 1,1 %