



# Product Data Sheet

S 'Submerged arc welding'

# OK Flux 10.61

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006031	Cancelling EN003712	Reg date 2013-04-04	Page 1 (2)
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## REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. Approvals: Sepros deleted.

## GENERAL

Agglomerated fluoride-basic flux for Submerged Arc Welding. Designed for single-wire butt welding when high impact properties at low temperatures are required. For general construction, pressure vessels, power generation, transport industries, etc. Suitable for DC only. Single layer and multi layer welding of unlimited plate thickness.

## CLASSIFICATIONS Flux

EN ISO 14174 S A FB 1 65 DC

## APPROVALS

CE EN 13479  
DB 51.039.03

## APPROVAL COMMENT

All others: See Flux-Wire combinations

## SLAG TYPE

Fluoride-basic

## CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al <sub>2</sub> O <sub>3</sub> +MnO	15	
CaF <sub>2</sub>	25	
CaO+MgO	40	
SiO <sub>2</sub> +TiO <sub>2</sub>	15	

## Other properties:

<b>Alloy Transfer</b>	Slightly Silicon and no Manganese alloying
<b>Basicity (Boniszewski)</b>	nom: 2.6
<b>Bulk Density</b>	nom: 1.1 kg/dm <sup>3</sup>
<b>Grain Size</b>	0.2-1.6 mm (10x65 mesh)

## WELDING POLARITY

DC+

## FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
26	0.7	
30	1.0	
34	1.3	
38	1.6	
<b>Current (A):</b>	580	
<b>Travel Speed (cm/min):</b>	55	
<b>Dimension (mm):</b>	Ø 4.0	



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## REDRYING

For hydrogen sensitive applications or when flux has picked up moisture: 300 +/- 25°C (570 +/- 45°F), 2 - 4 h

For hydrogen uncritical applications and when handled and stored in suitable ways: Not necessary.

## METALLURGICAL BEHAVIOR

Single Wire, Ø 4.0 mm, DC+, 30 V, 60 cm/min

