



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.62

Prepared by Jenny Broström	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006205	Cancelling EN006032	Reg date 2013-09-09	Page 1 (2)
-------------------------------	------------------------------	-------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

Classifications Flux, Hydrogen, Redrying and General text modified.

GENERAL

Agglomerated fluoride-basic flux for Submerged Arc Welding. Primarily for multi-run welding. For highest demands on impact properties, low temperature toughness, strength and CTOD-values. Especially suitable for narrow gap welding due to good slag detachability and smooth side-wall blending. For Offshore constructions, pressure vessels, power generation, shipbuilding, pipe mills, civil constructions, transport industries, etc. Produces low-oxygen weld metal (approx. 300 ppm) with hydrogen contents maximum 5 ml/100 g, in BlockPac (moisture protection) maximum 4 ml/100g. Operates optimally at the lower end of the voltage range. Designed for single and multi wire procedures, for butt and fillet welds. Works equally well on DC and AC current. Single layer and multi layer welding of unlimited plate thickness.

CLASSIFICATIONS Flux

EN ISO 14174	S A FB 1 55 AC H4 only BlockPac/moisture protection
EN ISO 14174	S A FB 1 55 AC H5

APPROVALS

CE	EN 13479
DB	51.039.07

APPROVALS (SPECIFIC)

NAKS/HAKC	RD 03-613-03	PL
-----------	--------------	----

APPROVAL COMMENT

All others: See Flux-Wire combinations

SLAG TYPE

Fluoride-basic

CHEMICAL COMPOSITION

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

Other properties:

Alloy Transfer	No Silicon or Manganese alloying
Basicity (Boniszewski)	nom: 3.2
Bulk Density	nom: 1.1 kg/dm ³
Grain Size	0.2-1.6 mm (10x65 mesh)
Hydrogen	max 5 ml H/100g weld metal (Redried flux); max 4 ml H/100g in BlockPac (moisture protection)

WELDING POLARITY

DC+, AC



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.62

Prepared by Jenny Broström	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006205	Cancelling EN006032	Reg date 2013-09-09	Page 2 (2)
-------------------------------	------------------------------	-------------------------------	--------------------	------------------------	------------------------	---------------

FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
26	0.7	0.6
30	1.0	0.9
34	1.3	1.2
38	1.6	1.4

Current (A): 580
Travel Speed (cm/min): 55
Dimension (mm): Ø 4.0

REDRYING

For hydrogen sensitive applications or when flux has picked up moisture: For H5: 300 +/- 25°C (570 +/- 45°F), 2 - 4 h.

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

Flux delivered in BlockPac (moisture protection) performs to H4 when bags are undamaged.

Please view special brochure for further information. If bag is damaged or flux has picked up moisture:

For H5: Redrying: See above.

For H4: 400 +/- 25°C (750°F +/- 45°F), 2 - 4 h.

METALLURGICAL BEHAVIOR

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

