



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.63

Prepared by Markus Gustafsson	Qualified by P-O Oskarsson	Approved by Martin Gehring	Reg no EN007509	Cancelling EN006033	Reg date 2017-03-30	Page 1 (2)
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REASON FOR ISSUE

General description amended

GENERAL

Agglomerated fluoride-basic flux for Submerged Arc Welding. Designed for multi-run welding of creep resistant Cr-, Mo-alloyed steels when highest toughness values are required also after step cooling treatment. Very low level of impurities and thus exceptionally clean weld metal. X-factor max. 12, partly max. 15 with specific wires. Mainly for petrochemical and chemical industries, power generation, pressure vessels, etc. Suitable for narrow gap welding. Low-oxygen weld metal (approx. 300 ppm) with hydrogen contents lower than 5 ml/100 g. Operates optimally at the lower end of the voltage range. Designed for single and multi wire procedures, welds equally well on DC and AC current. Mainly for multi layer welding of unlimited plate thickness.

CLASSIFICATIONS Flux

EN ISO 14174 S A FB 1 55 AC H5

APPROVALS

NAKS/HAKC RD 03-613-03 PL

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: 3.0
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)

WELDING POLARITY

DC+, AC

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



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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

