



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.69

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006034	Cancelling EN003715	Reg date 2013-04-04	Page 1 (1)
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REASON FOR ISSUE

Classification according to EN ISO 14174 and Approval Comment added.

GENERAL

Agglomerated basic flux specially designed as a backing flux for one-sided Submerged Arc Welding. Perfect root formation with smooth route surface. Good capability to support the molten pool even at high heat inputs. Mainly for shipbuilding industries. A copper bar with groove is normally used to support the flux.

CLASSIFICATIONS Flux

EN ISO 14174 S A CS 4

APPROVAL COMMENT

No approvals needed (see: Other data)

SLAG TYPE

Calcium-silicate

CHEMICAL COMPOSITION

Flux (%)	
	Nom
Fe	10
Al ₂ O ₃ +MnO	5
CaF ₂	5
CaO+MgO	40
SiO ₂ +TiO ₂	35

Other properties:

Alloy Transfer	No alloying
Basicity (Boniszewski)	nom: 1.8
Bulk Density	nom: 1.3 kg/dm ³
Grain Size	0.2-1.25 mm (14x65 mesh)

REDRYING

When handled and stored in suitable ways: Usually not necessary.

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

OTHER DATA

This flux is a backing flux for one-side Submerged Arc Welding. It does not take part of the welding process in a metallurgical way. Thus no alloying takes place from this flux.