



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.71

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006037	Cancelling EN004834	Reg date 2013-04-04	Page 1 (2)
-------------------------------	------------------------------	-------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. Approvals: NAKS / HU added.

GENERAL

Agglomerated aluminate-basic flux for Submerged Arc Welding. General purpose flux with excellent welding performance, suitable for all kinds of steels. High impact toughness values. Fits to a large range of SAW wires. For general constructions, pressure vessels, shipbuilding, pipe mills, wind tower productions, transport industries, etc. Designed for single and multi wire procedures, for butt and fillet welds. Suitable for DC and AC welding. Single layer and multi layer welding of unlimited plate thickness.

CLASSIFICATIONS Flux

EN ISO 14174 S A AB 1 67 AC H5

APPROVALS

CE EN 13479
DB 51.039.05

APPROVALS (SPECIFIC)

NAKS/HAKC RD 03-613-03 PL, RU, HU

APPROVAL COMMENT

All others: See Flux-Wire combinations

SLAG TYPE

Aluminate-basic

CHEMICAL COMPOSITION

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

Other properties:

Alloy Transfer	Slightly Silicon and moderately Manganese alloying
Basicity (Boniszewski)	nom: 1.5
Bulk Density	nom: 1.2 kg/dm ³
Grain Size	0.2-1.6 mm (10x65 mesh) or 0.315 -2.0 mm (9x48 mesh)
Hydrogen	max 5 ml H/100g weld metal (Redried flux)

WELDING POLARITY

DC+, AC



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.71

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006037	Cancelling EN004834	Reg date 2013-04-04	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

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

METALLURGICAL BEHAVIOR

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

