



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.72

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006039	Cancelling EN004835	Reg date 2013-04-04	Page 1 (2)
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REASON FOR ISSUE

EN 760 replaced by EN ISO 14174.

GENERAL

Agglomerated aluminate-basic flux for Submerged Arc Welding especially for applications with toughness requirements at low temperature. Excellent slag removal also in narrow V-joints. For wind tower productions, pressure vessels, general constructions etc. Extremely high current carrying capacity. For single or multi wire procedures. 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 57 AC H5

APPROVALS

CE EN 13479
DB 51.039.12

APPROVAL COMMENT

All others: See Flux-Wire combinations

SLAG TYPE

Aluminate-basic

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃ +MnO	30	
CaF ₂	20	
CaO+MgO	25	
SiO ₂ +TiO ₂	20	

Other properties:

Alloy Transfer	No Silicon and moderately Manganese alloying
Basicity (Boniszewski)	nom: 1.9
Bulk Density	nom: 1.2 kg/dm ³
Grain Size	0.315-2.0 mm (9x48 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

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

