



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.76

Prepared by M Gustafsson	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006040	Cancelling EN004076	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 particular for applications with high dilution from the base material, e.g. butt welds with one run from each side or fillet welds. Good impact properties due to high alloying of Mn and Si. Especially designed to be used with OK Autrod 12.10. Mainly for shipbuilding, also for pressure vessels, transport industries, general constructions, etc. Suitable for single and multi wire procedures, for DC and AC welding. Intended for a limited number of passes and plate thickness up to about 25 mm.

CLASSIFICATIONS Flux

EN ISO 14174 S A AB 1 89 AC

APPROVALS

CE EN 13479
DB 51.039.11

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 High Silicon and very high Manganese alloying
Basicity (Boniszewski) nom: 1.5
Bulk Density nom: 1.2 kg/dm³
Grain Size 0.2-1.6 mm (10x65 mesh)

WELDING POLARITY

DC+, AC



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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

