



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.81

Prepared by M Gustafsson	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006043	Cancelling EN003724	Reg date 2013-04-04	Page 1 (2)
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REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. General description and Other properties (Grain Size) modified.
Approvals: Sepros deleted, NAKS added.

GENERAL

Agglomerated, aluminate-rutile, low basicity flux for Submerged Arc Welding. Top-class surface finish and excellent slag detachability. High welding speeds. For pressure vessels, general construction, automotive, beam fabrication, low requirement pipeline steels, etc. Fine grained version especially for membrane wall panel fabrication. For butt welds and especially for concave horizontal fillet welds. Suitable for single and multi wire procedures, for DC and AC. Due to high Si-alloying intended for a limited number of passes and plate thickness up to about 25 mm.

CLASSIFICATIONS Flux

EN ISO 14174 S A AR 1 97 AC

APPROVALS

CE EN 13479

DB 51.039.04

APPROVALS (SPECIFIC)

NAKS/HAKC RD 03-613-03 PL

APPROVAL COMMENT

All others: See Flux-Wire combinations

SLAG TYPE

Aluminate-rutile

CHEMICAL COMPOSITION

	Flux (%)
	Nom
Al ₂ O ₃ +MnO	55
CaF ₂	5
CaO+MgO	5
SiO ₂ +TiO ₂	30

Other properties:

Alloy Transfer	Very high Silicon and moderately Manganese alloying
Basicity (Boniszewski)	nom: 0.6
Bulk Density	nom: 1.2 kg/dm ³
Grain Size	0.2-1.6 mm (10x65 mesh) or 0.2-1.25 mm (14x65 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

