



# Product Data Sheet

S 'Submerged arc welding'

# OK Flux 10.83

Prepared by M Gustafsson	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006044	Cancelling EN003882	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-rutile, low basicity flux for Submerged Arc Welding. High welding speeds. Smooth weld beads and excellent slag detachability. For general construction, membrane wall panels, beam fabrications, automotive (wheels), etc. Primarily used with single- or twin-arc wire systems. For DC and AC. For single pass butt welds, overlap welds and fillet welds at high speeds.

## CLASSIFICATIONS Flux

EN ISO 14174 S A AR 1 85 AC

## APPROVALS

CE EN 13479

## APPROVAL COMMENT

All others: See Flux-Wire combinations

## SLAG TYPE

Aluminate-rutile

## CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al <sub>2</sub> O <sub>3</sub> +MnO	50	
CaF <sub>2</sub>	5	
SiO <sub>2</sub> +TiO <sub>2</sub>	40	

## Other properties:

<b>Alloy Transfer</b>	High Silicon, no Manganese alloying
<b>Basicity (Boniszewski)</b>	nom: 0.3
<b>Bulk Density</b>	nom: 1.2 kg/dm <sup>3</sup>
<b>Grain Size</b>	0.2-1.6 mm (10x65 mesh)

## 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

<b>Current (A):</b>	580
<b>Travel Speed (cm/min):</b>	55
<b>Dimension (mm):</b>	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

