



# Product Data Sheet

S 'Submerged arc welding'

# OK Flux 10.87

Prepared by M Gustafsson	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006045	Cancelling EN003907	Reg date 2013-04-04	Page 1 (2)
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## REASON FOR ISSUE

EN 760 replaced by EN ISO 14174, Approvals statement added.

## GENERAL

Agglomerated, aluminate-rutile, low basicity flux for Submerged Arc Welding. Perfect wetting in butt-, overlap- and fillet welds. High welding speeds. For air compressor tanks, LPG bottles, general construction, automotive, etc. Suitable for single and multi wire procedures, for DC and AC. Intended for a limited number of passes and plate thicknesses up to about 25 mm.

## CLASSIFICATIONS Flux

EN ISO 14174 S A AR 1 95 AC

## APPROVALS

Not applicable

## SLAG TYPE

Aluminate-rutile

## CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al <sub>2</sub> O <sub>3</sub> +MnO	50	
CaF <sub>2</sub>	5	
CaO+MgO	5	
SiO <sub>2</sub> +TiO <sub>2</sub>	35	

## Other properties:

<b>Alloy Transfer</b>	Very high Silicon alloying, neutral on Manganese
<b>Basicity (Boniszewski)</b>	nom: 0.4
<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	0.6	0.5
30	0.9	0.7
34	1.2	1.0
38	1.5	1.3

  

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



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## METALLURGICAL BEHAVIOR

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

