



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.88

Prepared by M Gustafsson	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006046	Cancelling EN004300	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 flux for Submerged Arc Welding with high tolerance against rust and mill scale. Excellent slag removal and smooth weld bead surface. Very good toughness values. For general constructions, beam fabrications, pressure vessels, ship building, transport industries, etc. Suitable for DC and AC welding. Single layer and multi layer welding of up to about 30 mm plate thickness.

CLASSIFICATIONS Flux

EN ISO 14174 S A AR 1 89 AC

APPROVAL COMMENT

See Flux-Wire combinations

SLAG TYPE

Aluminate-rutile

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃ +MnO	50	
CaF ₂	10	
CaO+MgO	5	
SiO ₂ +TiO ₂	30	

Other properties:

Alloy Transfer	High Silicon and very high Manganese alloying
Basicity (Boniszewski)	nom: 0.7
Bulk Density	nom: 1.2 kg/dm ³
Grain Size	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

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



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METALLURGICAL BEHAVIOR

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

