Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.92

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. NAKS approval added.

GENERAL

OK Flux 10.92 is an neutral, agglomerated Cr-compensating flux designed for strip cladding, butt and fillet welding of stainless and corrosion resistant steel types.

Good welding characteristics and easy slag removal.

CLASSIFICATIONS Flux

EN ISO 14174 S A CS 2 57 53 DC

APPROVALS (SPECIFIC)

NAKS/HAKC RD 03-613-03 CZ

APPROVAL COMMENT

All others: See Flux-Wire/Strip combinations

SLAG TYPE

Calcium silicate SiO2-MgO-Al2O3-(CaF2)

CHEMICAL COMPOSITION

	Flux (%)
	Nom
Al2O3+MnO	20
CaF2	10
CaO+MgO	30
SiO2+TiO2	35

Other properties:

Alloy Transfer	Chromium compensating
Basicity (Boniszewski)	nom: 1.0
Max Amperage Strip	1200 A

FLUX CONSUMPTION

(kg Flux / kg Wire/Strip)

Arc Voltage	DC+	AC
26	0.4	
30	0.55	
34	0.7	
38	0.9	

Current (A):	580
Travel Speed (m/h):	33
Dimension (mm):	4.0

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OTHER DATA

* Flux consumption when strip cladding:
Strip size: 60 x 0.5 mm
DC+, 750 A, 26 - 28 V, 7 m/h
Flux consumption = 0.65 kg flux/kg strip
* The flux is delivered in plastic-lined paperbags containing 25 kg.