



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.93

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REASON FOR ISSUE

Flux consumption data amended.

GENERAL

Basic, agglomerated flux for butt welding of stainless steels.

A suitable flux for welding of high alloyed CrNi-steels like e.g. duplex stainless steel.

The low Si addition during welding provides good mechanical properties in the weld metal.

CLASSIFICATIONS Flux

EN ISO 14174 S A AF 2 56 54 DC

APPROVALS

CE EN 13479
DB 51.039.10
NAKS/HAKC RD 03-613-03 CZ

APPROVAL COMMENT

All others: See Flux-Wire combinations

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃-SiO₂

CHEMICAL COMPOSITION

	Flux (%)
	Nom
Al ₂ O ₃ +MnO	40
CaF ₂	50
SiO ₂ +TiO ₂	10

Other properties:

Alloy Transfer Non alloying
Basicity (Boniszewski) nom: 1.9
Bulk Density nom: 1.0 kg/dm³

FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
26	0.5	
30	0.6	
34	0.8	
38	1.0	
Current (A):	580	
Travel Speed (m/h):	33	
Dimension (mm):	4.0	