



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.94

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REASON FOR ISSUE

Nominal Basicity index amended (was 1.7).

GENERAL

Basic, chromium-compensating, agglomerated flux for butt welding of stainless steels.
Specially recommended for welding of stainless steels of the superduplex type.
Low Si addition during welding provides good mechanical properties in the weld metal.

CLASSIFICATIONS Flux

EN ISO 14174 S A AF 2 56 64 DC

APPROVALS

Not applicable

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃-SiO₂

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃ +MnO	35	
CaF ₂	50	
SiO ₂ +TiO ₂	10	

Other properties:

Alloy Transfer Chromium compensating

Basicity (Boniszewski) nom: 1.9

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

OTHER DATA

The flux is delivered in plastic-lined paperbags containing 25 kg.