



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.96

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006052	Cancelling EN002609	Reg date 2013-04-04	Page 1 (2)
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REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. Approval statement added.

GENERAL

A neutral, agglomerated chromium alloying flux for hardsurfacing purpose producing a weld metal with a hardness of about 35 HRC with a mild steel electrode.

CLASSIFICATIONS Flux

EN ISO 14174 S A CS 3 Cr3 DC

APPROVALS

Not applicable

SLAG TYPE

Calcium silicate SiO₂-MgO-Al₂O₃-Cr

CHEMICAL COMPOSITION

	Flux (%)
	Nom
Cr	8
Al ₂ O ₃ +MnO	15
CaF ₂	10
SiO ₂ +TiO ₂	35

Other properties:

Alloy Transfer Chromium alloying

Basicity (Boniszewski) nom: 0.7

FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
30	0.7	0.6
34	0.9	0.8
38	1.2	1.0

Current (A): 580

Travel Speed (m/h): 33

Dimension (mm): 4.0



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OTHER DATA

Recommended data for hardfacing:

Wire diameter (mm) Amperage (A) Arc Voltage (V)

3.0 300 - 500 28 - 38

4.0 450 - 650 30 - 38

5.0 550 - 800 30 - 38

* When surfacing cylindrical objects, the recommended arc voltage should not be higher than 34 V.

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