OK Flux 10.61

OK Flux 10.61 is an agglomerated, high-basic flux for submerged arc welding. It is used for single and multi-run butt welding when demands on impact toughness values are high. This is a good alternative to other high basic fluxes when welding is done with single wire DC+.
The flux alloys very little Si and Mn to the weld metal and thus it is well suited for welding of unlimited plate thicknesses.
OK Flux 10.61 is used in general construction, pressure vessel construction, power generation and transport industries.

Klasyfikacje	EN ISO 14174 : S A FB 1 65 DC
Dopuszczenia	CE EN 13479

Atesty zależne są od lokalizacji zakładu. W celu otrzymania dalszych informacji prosimy skontaktować się z przedstawicielem ESAB.

Typ żużlu	Fluoride-basic
Transfer składnika stopowego	Slightly Silicon and no Manganese alloying
Gęstość	nom 1.1 kg/dm3
Wskaźnik zasadowości	nom 2.6
Granulacja	0.2-1.6 mm (10x65 mesh)

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.7 kg	-
30 V	1.0 kg	-
34 V	1.3 kg	-
38 V	1.6 kg	-

Dimensions	Amps	Travel Speed
Ø 4.0 mm	580 A	55 cm/min

Classifications

Wire	AWS/EN	EN - As Welded	AWS - As Welded	AWS - PWHT
OK Autrod 12.10	A5.17:EL12/ 14171-A:S1	14171-A: S 35 2 FB S1	-	-
OK Autrod 12.22	A5.17:EM12K/ 14171-A:S2Si	14171-A: S 38 4 FB S2Si	A5.17: F7A8-EM12K	A5.17: F6P8-EM12K
OK Autrod 12.24	A5.23:EA2/ 14171-A:S2Mo; 24598-A:S S Mo	14171-A: S 42 2 FB S2Mo	A5.23: F7A4-EA2-A2	A5.23: F7P2-EA2-A2
OK Autrod 12.32	A5.17:EH12K/ 14171-A:S3Si	14171-A: S 42 5 FB S3Si	A5.17: F7A6-EH12K	A5.17: F7P8-EH12K
OK Autrod 12.40	A5.17:EH14	14171-A: S 46 3 FB S4	A5.17: F7A6-EH14	A5.17: F7P6-EH14
OK Autrod 12.40	A5.17:EH14/ 14171-A:S4	14171-A: S 46 3 FB S4	A5.17: F7A6-EH14	A5.17: F7P6-EH14
OK Autrod 13.10 SC	A5.23:EB2R/ 24598-A:S S CrMo1	-	-	A5.23: F8P2-EB2R-B2
OK Autrod 13.20 SC	A5.23:EB3R/ 24598-A:S S CrMo2	-	-	A5.23: F8P0-EB3R-B3
OK Autrod 13.36	A5.23:EG/ 14171-A:S2Ni1Cu	14171-A: S 46 3 FB S2Ni1Cu	-	-

Approvals

Wire	DB	CE	VdTÜV
OK Autrod 12.10	•	•	•
OK Autrod 12.22	-	•	-
OK Autrod 12.24	-	•	•
OK Autrod 12.32	-	•	-
OK Autrod 13.10 SC	•	•	•
OK Autrod 13.20 SC	-	-	•
OK Autrod 13.36	•	•	-

Typical Mechanical Properties

Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.10	As Welded EN DC+	375 MPa	445 MPa	30 %	180 J @ 20°C 130 J @ -10°C 100 J @ -20°C

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Typical Mechanical Properties					
Wire	**Condition**	**Yield Strength**	**Tensile Strength**	**Elongation**	**Charpy V-Notch**
OK Autrod 12.22	As Welded AWS DC+	440 MPa	520 MPa	30 %	120 J @ -20°C 85 J @ -30°C 75 J @ -40°C 35 J @ -62°C
OK Autrod 12.22	As Welded EN DC+	430 MPa	500 MPa	30 %	130 J @ -20°C 80 J @ -30°C 70 J @ -40°C 35 J @ -62°C
OK Autrod 12.24	As Welded AWS DC+	480 MPa	570 MPa	26 %	130 J @ 20°C 120 J @ 0°C 80 J @ -20°C 45 J @ -29°C 35 J @ -40°C
OK Autrod 12.24	As Welded EN DC+	480 MPa	560 MPa	26 %	130 J @ 20°C 120 J @ 0°C 80 J @ -20°C 45 J @ -29°C 35 J @ -40°C
OK Autrod 12.32	As Welded AWS DC+	450 MPa	560 MPa	27 %	120 J @ -20°C 100 J @ -40°C 55 J @ -51°C 35 J @ -62°C
OK Autrod 12.32	As Welded EN DC+	450 MPa	550 MPa	26 %	110 J @ -20°C 90 J @ -40°C 55 J @ -50°C 40 J @ -62°C
OK Autrod 12.40	As Welded AWS DC+	490 MPa	580 MPa	26 %	60 J @ -30°C 40 J @ -40°C 35 J @ -51°C
OK Autrod 12.40	As Welded EN DC+	490 MPa	570 MPa	25 %	60 J @ -30°C 40 J @ -40°C 35 J @ -51°C
OK Autrod 13.36	As Welded 580A, 29V, 55cm/min DC+	545 MPa	640 MPa	25 %	70 J @ -20°C 55 J @ -30°C 40 J @ -40°C 35 J @ -50°C

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**Cu**
OK Autrod 12.10 DC+, 580A, 29V						
0.07	0.5	0.15	-	-	-	-
OK Autrod 12.22 DC+, 580A, 29V						
0.08	1.0	0.35	-	-	-	-
OK Autrod 12.24 DC+, 580A, 29V						
0.06	1.0	0.25	-	-	0.5	-
OK Autrod 12.32 DC+, 580A, 29V						
0.09	1.4	0.3	-	-	-	-
OK Autrod 12.40 DC+, 580A, 29V						
0.08	1.8	0.15	-	-	-	-
OK Autrod 13.10 SC DC+, 580A, 29V						
0.08	0.7	0.30	-	1.1	0.5	-
OK Autrod 13.20 SC DC+, 580A, 29V						
0.08	0.8	0.3	-	2.1	1.0	-
OK Autrod 13.36 DC+, 580A, 29V, 55cm/min						
0.07	1.0	0.5	0.7	0.2	-	0.4

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