



OK Flux 10.90

Agglomerated aluminate-fluoride-basic flux for welding of 9 % Ni steels and other high alloyed steels with Ni based wires. The flux is manganese adding, which reduces the risk of hot cracking. Good slag detachability and nice bead appearance.

Klasyfikacje	EN ISO 14174 : S A AF 2 55 53 MnNi DC
Dopuszczenia	NAKS/HAKC RD 03-613-03

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

Typ żużłu	Fluoride basic CaF ₂ -Al ₂ O ₃ -SiO ₂
Transfer składnika stopowego	Chromium compensating, Nickel- and manganese alloying.
Gęstość	nom 1.0 kg/dm ³
Wskaźnik zasadowości	nom 1.7

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.5 kg	-
30 V	0.6 kg	-
34 V	0.8 kg	-
38 V	1.0 kg	-

Dimensions	Amps	Travel Speed
4.0 mm	580 A	33 m/h

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
OK Autrod 310	A5.9:ER310/ 14343-A:S 25 20	
OK Autrod NiCr-3	A5.14:ERNiCr-3/ 18274:S Ni 6082 (NiCr ₂₀ Mn ₃ Nb)	
OK Autrod NiCrMo-13	A5.14:ERNiCrMo-13/ 18274:S Ni 6059 (NiCr ₂₃ Mo ₁₆)	
OK Autrod NiCrMo-3	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr ₂₂ Mo ₉ Nb)	A5.39: F100A32-ERNiCrMo-3/G
OK Autrod NiCrMo-3	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr ₂₂ Mo ₉ Nb)	A5.39: F100A32-ERNiCrMo-3/G
OK Autrod NiCrMo-3 SAW	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr ₂₂ Mo ₉ Nb)	
OK Autrod NiCrMo-4	A5.14:ERNiCrMo-4/ 18274:S Ni 6276 (NiCr ₁₅ Mo ₁₆ Fe ₆ W ₄)	A5.39: F100A32-ERNiCrMo-4/G
OK Autrod NiCrMo-4	A5.14:ERNiCrMo-4/ 18274:S Ni 6276 (NiCr ₁₅ Mo ₁₆ Fe ₆ W ₄)	A5.39: F100A32-ERNiCrMo-4/G

Approvals

Combined with Wire	ABS	BV	DNV	RINA	CCS	ClassNK	KR	DNV-GL
OK Autrod NiCrMo-3	-	-	-	-	-	-	-	•
OK Autrod NiCrMo-3 SAW	-	-	•	-	-	-	-	-
OK Autrod NiCrMo-4	•	•	•	•	•	•	•	•

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 310	As Welded ISO DC+ hr °C	390 MPa	570 MPa	34 %	85 J @ 20°C
OK Autrod NiCr-3	As Welded ISO DC+ hr °C	400 MPa	600 MPa	35 %	145 J @ -80°C 130 J @ -196°C
OK Autrod NiCrMo-13	As Welded 350 A, HI 1.3-1.7 kJ/mm DC+ hr °C	470 MPa	675 MPa	46 %	70 J @ -196°C
OK Autrod NiCrMo-3	As Welded HI ~1.0-1.7 kJ/mm DC+ hr °C	440 MPa	720 MPa	42 %	100 J @ -196°C 100 J @ -196°C
OK Autrod NiCrMo-3 SAW	As Welded HI ~1.0-1.7 kJ/mm DC+ hr °C	440 MPa	720 MPa	42 %	100 J @ -196°C
OK Autrod NiCrMo-4	As Welded DC+ hr °C	480 MPa	700 MPa	40 %	60 J @ -196°C 60 J @ -196°C



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Typowy skład chemiczny stopiwa %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
OK Autrod 310									
0.07	3.2	0.40	0.010	0.020	20.5	25.5	0.015	-	0.010
OK Autrod NiCrMo-13 Current Type: DC+ , 350A, 29V									
0.01	2.8	0.2	0.001	0.01	bal.	22.0	15.0	-	-
OK Autrod NiCrMo-3 DC+, 350A, 29V									
0.01	1.7	0.2	0.01	0.01	Bal.	21.0	8.5	-	-
OK Autrod NiCrMo-4 DC+, 350A, 29V									
0.01	2.2	0.2	0.003	0.01	Bal.	15.0	15.5	0.04	0.01

Co	Fe	Nb+Ta	W
OK Autrod 310			
-	-	-	-
OK Autrod NiCrMo-13 Current Type: DC+ , 350A, 29V			
-	1	-	-
OK Autrod NiCrMo-3 DC+, 350A, 29V			
-	2.0	3.0	-
OK Autrod NiCrMo-4 DC+, 350A, 29V			
0.15	6.0	-	3.4