

OK Flux 10.10

Type Basic

ESW

Description

OK Flux 10.10 is an agglomerated flux, designed for electroslag strip surfacing. This flux is particularly suitable for strip surfacing with stainless strips of the Cr, CrNi and CrNiMo types, with or without Nb stabilisation. The weldability, bead appearance and slag removal of OK Flux 10.10 are excellent.

General

20 kg weld metal/h with the parameters: DC+, 1250 A, 25 V, 9 m/h, using a 60 mm wide strip.

Density

≈1.0 kg/dm³

Basicity index

4.0

Flux consumption as kg flux/kg wire

Voltage	DC+
25	0.5

Classifications

DIN 32522 BFB 6 63356 DC 17 B 1-16

Typical all weld metal composition

Consumable	%C	%Si	%Mn	%Cr	%Ni	%Mo	Other	Ferrite
1. "308L" overlay combination on 2.25Cr 1Mo steel, typical parameters: DC+, 1250 A, 25 V, 9 m/h								
OK Band 309L ESW	0.015	0.2	1.8	21	11.4	-	-	-
Weld composition 1st layer	0.023	0.45	1.2	18.5	10	-	-	FN 6
2. "347" overlay combination on 2.25Cr 1Mo steel, typical parameters: DC+, 1250 A, 25 V, 9 m/h								
OK Band 309LNb ESW	0.015	0.2	1.8	21	11	-	Nb=0.5	-
Weld composition 1st layer	0.023	0.47	1.2	19	10	-	Nb=0.4	FN 7
3. "316" overlay combination on 2.25Cr 1Mo steel, typical parameters: DC+, 1250 A, 25 V, 9 m/h								
OK Band 309LMo ESW	0.015	0.2	1.8	20	13.7	2.7	-	-
Weld composition 1st layer	0.024	0.4	1.2	18	12	2.7	-	FN 8