

OK Flux 10.90

SAW

Type Fluoride-basic SA AF 2 CrNi DC

Description

OK Flux 10.90 is an agglomerated fluoride basic flux for welding 9% Ni steels and other high-alloyed steels. The flux adds manganese, which reduces the risk of hot cracking. Good slag detachability and attractive bead appearance.

Density

1.0 kg/dm³

Basicity index

1.7

Flux consumption as kg flux/kg wire

Voltage	DC
26	0.5
30	0.6
34	0.8
38	1.0

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 19.81	0.001	0.2	3.0	22.0	bal.	14.0
OK Autrod 19.82	0.01	0.2	1.5	21.0	bal.	8.5

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 19.81	470	675	-196	70
OK Autrod 19.82	440	720	-196	90

Classifications

Wire	EN ISO 18274	SFA/AWS A5.14
OK Autrod 19.81	S Ni 6059 (NiCr23Mo16)	ERNiCrMo-13
OK Autrod 19.82	S Ni 6625 (NiCr22Mo9Nb)	ERNiCrMo-3