

OK Flux 10.10

High basic, all mineral, agglomerated flux designed for electro slag strip surfacing.

The flux is particularly suitable for strip cladding with stainless strip of the Cr-, Cr-Ni- and Cr-Ni-Mo-steel types, with or without Nb.

Классификации	EN ISO 14174 : ES A FB 2B 56 44 DC
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Сварочный ток	1700 A (60 x 0.5 mm strip)
Тип шлака	Fluoride basic CaF ₂ -Al ₂ O ₃
Перенос легирующего элемента	Moderately silicon alloying
Плотность	nom 1.0 kg/dm ³
Показатель щелочности	nom 4.0

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
25 V	0.5 kg	-

Dimensions	Amps	Travel Speed
-	1250 A	9 m/h

Classifications

Wire	SFA/AWS - EN ISO
OK Band 309L ESW	14343-A:B 22 11 L
OK Band 309LMo ESW	A5.9:EQ309LMo (Mod)/ 14343-A:B 21 13 3 L
OK Band 309LNb ESW	14343-A:B 22 12 L Nb
OK Band 310MoL	14343-A:B 25 22 2 N L

Approvals

Combined with Wire	VdTÜV
OK Band 309LNb ESW	•

Хим. состав

Al ₂ O ₃	CaF ₂	SiO ₂ +MgO
25	63	8