

OK Flux 10.94

Basic, chromium-compensating, agglomerated flux for butt welding of stainless steels. Specially recommended for welding of stainless steels of the superduplex type. Low Si addition during welding provides good mechanical properties in the weld metal.

Классификации	EN ISO 14174 : S A AF 2 56 64 DC
Тип шлака	Fluoride basic CaF ₂ -Al ₂ O ₃ -SiO ₂
Перенос легирующего элемента	Chromium compensating
Плотность	nom 1.0 kg/dm ³
Показатель щелочности	nom 1.9

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 2209	A5.9:ER2209/ 14343-A:S 22 9 3 N L	
OK Autrod 2509	A5.9:ER2594/ 14343-A:S 25 9 4 N L	A5.39: F120A8-ER2594/2594
OK Autrod 2509	A5.9:ER2594/ 14343-A:S 25 9 4 N L	A5.39: F120A8-ER2594/2594
OK Autrod 308L	A5.9:ER308L/ 14343-A:S 19 9 L	
OK Autrod 347	A5.9:ER347/ 14343-A:S 19 9 Nb	

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 2209	As Welded DC+ hr	630 MPa	780 MPa	30 %	60 J @ -40°C 42 J @ -60°C
OK Autrod 2509	As Welded DC+ hr	625 MPa	830 MPa	28 %	90 J @ 20°C 50 J @ -60°C
OK Autrod 2509	As Welded DC+ hr	680 MPa	870 MPa	25 %	70 J @ 20°C 50 J @ -60°C
OK Autrod 308L	As Welded hr	400 MPa	560 MPa	40 %	85 J @ 20°C 70 J @ -40°C 60 J @ -60°C
OK Autrod 308L	As Welded DC+ hr	400 MPa	560 MPa	40 %	85 J @ 20°C 70 J @ -40°C 60 J @ -60°C
OK Autrod 347	As Welded	455 MPa	620 MPa	35 %	100 J @ 20°C 70 J @ -60°C 50 J @ -110°C 30 J @ -196°C
OK Autrod 347	As Welded DC+ hr	455 MPa	620 MPa	38 %	100 J @ 20°C 70 J @ -60°C 50 J @ -110°C 30 J @ -196°C

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
OK Autrod 2209 Current: DC+, 420A, 27V									
0.01	1.3	0.6	0.01	0.02	8.5	23.0	3.0	0.1	0.14
OK Autrod 2509 Current: DC+, 400A, 28V, 48cm/min									
0.02	0.4	0.45	0.01	0.017	9.3	24.5	3.5	0.10	0.24
OK Autrod 308L DC+									
0.02	1.4	0.5	-	-	9.5	20	0.2	0.1	-
OK Autrod 347 DC+									
0.04	1.0	0.5	-	-	9.6	19.6	-	-	-



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Nb	W	FN WRC-92
OK Autrod 2209 Current: DC+, 420A, 27V		
-	-	45
OK Autrod 2509 Current: DC+, 400A, 28V, 48cm/min		
-	<0.002	54
OK Autrod 308L DC+		
-	-	11
OK Autrod 347 DC+		
0.5	-	9