

OK Flux 10.63

Agglomerated fluoride-basic flux for Submerged Arc Welding. Designed for multi-run welding of creep resistant Cr-, Mo-alloyed steels when highest toughness values are required also after step cooling treatment. Very low level of impurities and thus exceptionally clean weld metal. X-factor max. 12, partly max. 15 with specific wires. Mainly for petrochemical and chemical industries, power generation, pressure vessels, etc. Suitable for narrow gap welding. Low-oxygen weld metal (approx. 300 ppm) with hydrogen contents lower than 5 ml/100 g. Operates optimally at the lower end of the voltage range. Designed for single and multi wire procedures, welds equally well on DC and AC current. Mainly for multi layer welding of unlimited plate thickness.

Классификации	EN ISO 14174 : S A FB 1 55 AC H5
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Диффузионный водород	max 5 ml H/100g weld metal (Redried flux)
Тип шлака	Fluoride-basic
Перенос легирующего элемента	No Silicon or Manganese alloying
Плотность	nom 1.1 kg/dm ³
Показатель щелочности	nom 3.0
Размер гранулы	0.2-1.6 mm (10x65 mesh)

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.7 kg	0.6 kg
30 V	1.0 kg	0.9 kg
34 V	1.3 kg	1.2 kg
38 V	1.6 kg	1.4 kg

Dimensions	Amps	Travel Speed
Ø 4.0 mm	580 A	55 cm/min

Classifications

Wire	SFA/AWS - EN ISO	AWS - PWHT
OK Autrod 13.10 SC	A5.23:EB2R/ 24598-A:S S CrMo1	A5.23: F8P4-EB2R-B2R
OK Autrod 13.20 SC	A5.23:EB3R/ 24598-A:S S CrMo2	A5.23: F8P8-EB3R-B3R
OK Autrod 410NiMo	14343:S 13 4	

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 410NiMo	As Welded DC+ hr	900 MPa	1050 MPa	17 %	40 J @ 0°C 32 J @ -20°C

Хим. состав наплавленного металла

C	Mn	Si	Cr	Mo	Mn+Si	PE	J-Factor	X-bar
OK Autrod 13.10 SC AC, 565A, 30V								
0.08	0.85	0.20	1.15	0.5	1.1	2.1	100	<= 15
OK Autrod 13.10 SC DC+, 485A, 30V								
0.075	0.8	0.25	1.1	0.5	1.1	2.1	100	<= 15
OK Autrod 13.20 SC AC, 580A, 29V								
0.08	0.60	0.20	2.1	1.0	-	-	-	<= 15
OK Autrod 13.20 SC DC+, 580A, 29V								
0.07	0.60	0.20	2.1	1.0	-	-	-	<= 15