

OK Flux 10.88

Agglomerated aluminate-rutile flux for Submerged Arc Welding with high tolerance against rust and mill scale. Excellent slag removal and smooth weld bead surface. Very good toughness values. For general constructions, beam fabrications, pressure vessels, ship building, transport industries, etc. Suitable for DC and AC welding. Single layer and multi layer welding of up to about 30 mm plate thickness.

Классификации	EN ISO 14174 : S A AR 1 89 AC
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Тип шлака	Aluminate-rutile
Перенос легирующего элемента	High Silicon and very high Manganese alloying
Плотность	nom 1.2 kg/dm ³
Показатель щелочности	nom 0.7
Размер гранулы	0.2-1.6 mm (10x65 mesh)

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.6 kg	0.5 kg
30 V	0.9 kg	0.7 kg
34 V	1.2 kg	1.0 kg
38 V	1.5 kg	1.3 kg

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

Classifications

Wire	SFA/AWS - EN ISO	EN - As Welded	AWS - As Welded	AWS - PWHT
OK Autrod 12.10	A5.17:EL12/ 14171-A:S1	14171-A: S 38 0 AR S1	A5.17: F6AZ-EL12	
OK Autrod 12.20	A5.17:EM12/ 14171-A:S2	14171-A: S 42 2 AR S2	A5.17: F7A0-EM12	
OK Autrod 12.22	A5.17:EM12K/ 14171-A:S2Si	14171-A: S 42 2 AR S2Si	A5.17: F7A0-EM12K	A5.17: F6P0-EM12K

Approvals

Combined with Wire	ABS	BV	DNV	GL	LR
OK Autrod 12.22	•	•	•	•	•

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.10	As Welded AWS DC+ hr	400 MPa	470 MPa	30 %	70 J @ 0°C
OK Autrod 12.10	As Welded EN AC hr	450 MPa	500 MPa	30 %	60 J @ 0°C
OK Autrod 12.20	As Welded AWS DC+ hr	430 MPa	520 MPa	25 %	70 J @ 0°C 50 J @ -18°C
OK Autrod 12.20	As Welded EN AC hr	480 MPa	550 MPa	27 %	90 J @ 0°C 70 J @ -20°C
OK Autrod 12.22	As Welded AWS DC+	440 MPa	510 MPa	26 %	70 J @ 0°C 50 J @ -18°C
OK Autrod 12.22	As Welded EN AC	480 MPa	550 MPa	27 %	90 J @ 0°C 60 J @ -20°C
OK Autrod 12.22	As Welded EN AC hr	480 MPa	550 MPa	27 %	90 J @ 0°C 60 J @ -20°C

Хим. состав наплавленного металла

C	Mn	Si
OK Autrod 12.10 AC, 580A, 29V		
0.05	1.5	0.5
OK Autrod 12.10 DC+, 580A, 29V		
0.05	1.7	0.6
OK Autrod 12.20 AC, 580A, 29V		
0.05	1.6	0.5
OK Autrod 12.20 DC+, 580A, 29V		
0.05	1.8	0.6

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Хим. состав наплавленного металла

C	Mn	Si
OK Autrod 12.22 AC, 580A, 29V		
0.05	1.6	0.6
OK Autrod 12.22 DC+, 580A, 29V		
0.05	1.8	0.7