# OK Flux 10.05 SAW

**Type** Basic EN 760: SA Z 2 DC

## Description

OK Flux 10.05 is an agglomerated flux for submerged arc strip cladding. It is recommended for cladding with the Cr, CrNi and CrNiMo types of stainless strip. Slag removal and overlapping with this flux are excellent.

### General

15 kg weld metal/h with the parameters: DC+, 750 A, 28 V, 7 m/h, using 60 mm wide strip

### Density

≈0.7 kg/dm$^3$

### Basicity index

1.1

## Classifications

EN 760 SA Z 2 DC

## Flux consumption as kg flux/kg wire

| Voltage | DC+ |
|---|---|
| 25 | 0.4 |
| 28 | 0.5 |
| 32 | 0.6 |

## Approvals

| | |
|---|---|
| OK Flux 10.05/OK Band 316L | TÜV |
| OK Flux 10.05/OK Band 309L | TÜV |

## Typical all weld metal composition

| Consumable | %C | %Si | %Mn | %Cr | %Ni | %Mo | Other | Ferrite |
|---|---|---|---|---|---|---|---|---|
| 1. 308 L overlay combination on 2.25Cr 1Mo steel, typical parameters: DC+, 750 A, 28 V, 7 m/h | | | | | | | | |
| OK Band 309L | 0.020 | 0.4 | 1.9 | 23 | 13 | - | | |
| Weld composition 1st layer | 0.027 | 0.7 | 1.1 | 19 | 11.3 | - | - | FN 5 |
| OK Band 308L | 0.022 | 0.3 | 1.7 | 19.6 | 10.1 | - | - | - |
| Weld composition 2nd layer | 0.021 | 0.6 | 1.0 | 18.9 | 10.6 | - | - | FN 8 |
| 2. 347 overlay combination on 2.25Cr 1Mo steel, typical parameters: DC+, 750 A, 28 V, 7 m/h | | | | | | | | |
| OK Band 309L | 0.020 | 0.4 | 1.9 | 23 | 13 | - | - | - |
| Weld composition 1st layer | 0.024 | 0.6 | 1.1 | 19 | 10.6 | - | - | FN 4 |
| OK Band 347 | 0.018 | 0.4 | 1.7 | 19.3 | 10 | - | Nb=0.6 | - |
| Weld composition 2nd layer | 0.018 | 0.6 | 1.1 | 19.2 | 10.3 | - | Nb=0.3 | FN 7 |
| 3. 316 L overlay combination on 2.25Cr 1Mo steel, typical parameters: DC+, 750 A, 28 V, 7 m/h | | | | | | | | |
| OK Band 309L | 0.020 | 0.4 | 1.9 | 23 | 13 | - | - | - |
| Weld composition 1st layer | 0.028 | 0.7 | 1.1 | 19 | 11 | - | - | FN 5 |
| OK Band 316L | 0.017 | 0.4 | 1.8 | 18.2 | 13.1 | 2.8 | - | - |
| Weld composition 2nd layer | 0.018 | 0.7 | 1.1 | 18 | 12.9 | 2.1 | - | FN 7 |