

OK Flux 10.07

SAW

Type Neutral

EN 760: SA CS 2 NiMo DC

Description

Neutral, agglomerated nickel and molybdenum alloying flux, specially designed for the overlay welding of continuous cast rollers with OK Band 11.82 (EQ 430), producing a weld metal with 14 Cr-4 Ni-1 Mo and 370-420 HB. It can also be used for cladding with a 17 Cr wire, producing the same weld metal.

Density

≈1.0 kg/dm³

Basicity index

1.0

Classifications

Not applicable classification.

Flux consumption as kg flux/kg wire

Voltage	DC+
28	0.5

Typical all weld metal composition

Consumable	%C	%Si	%Mn	%Cr	%Ni	%Mo
OK Band 430	0.04	0.4	0.2	13.5	4.0	0.9