

OK Flux 10.11

SAW

Type Fluoride basic

Description

OK Flux 10.11 is very high basic agglomerated flux for electroslag strip cladding. The flux has low viscosity and is suitable for cladding with Ni-base, Co and fully-austenitic alloys due to its good wetting behaviour. It is also suitable for welding at higher travel speeds.

Density

1.0 kg/dm³

Basicity index

5.4

Flux consumption as kg flux/kg wire

Voltage	DC
25	0.5

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Band NiCr3	<0.05	<0.25	3.0	20.0	>67	<2.0
OK Band NiCrMo3	0.02	0.1	0.3	22.0	bal.	9.0

Classifications

Wire	EN ISO 18274	SFA/AWS A5.14
OK Band NiCr3	B Ni 6082 (NiCr20Mn3Nb)	ERNiCr-3
OK Band NiCrMo3	B Ni 6625 (NiCr22Mo9Nb)	ERNiCrMo-3