

OK Flux 10.14

ESW

Type Fluoride basic

Description

OK Flux 10.14 is a high basic, agglomerated flux for electroslag strip cladding. The flux is suitable for cladding with austenitic Cr, CrNi and CrNiMo strips at high travel speeds.

Density

1.0 kg/dm³

Basicity index

4.4

Flux consumption as kg flux/kg wire

Voltage	DC+
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25	0,5
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Typical all weld metal composition

Consumable	%C	%Si	%Mn	%Cr	%Ni	%Mo	Other	Ferrite
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1. "347" overlay combination on CMn steel, typical parameters: DC+, 2300 A, 25 V, 24 m/h

OK Band 309L ESW	0.01	0.2	1.8	24	12	-	Nb=0.7	-
Weld composition 1st layer	0.05	0.4	1.6	18.5	10	-	Nb=0.5	FN 5