

OK Flux 10.61

SAW

Type High-basic

EN 760:SA FB 1 65 DC

Description

OK Flux 10.61 is designed for the single-wire, multi-run butt welding of mild, medium and high tensile steels with impact strength requirements down to -40°C/-60°C.

Due to the non-alloying effect, OK Flux 10.61 is designed for use with a suitable alloying wire. OK Flux 10.61 can be used on DC±.

Density

≈1.1 kg/dm³

Basicity index

2.8

Flux consumption kg flux/kg wire

Voltage	DC+
26	0.6
30	0.9
34	1.15
38	1.4

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.24	0.06	0.25	1.0	-	-	0.5
OK Autrod 13.10 SC	0.08	0.30	0.7	1.1	-	0.5
OK Autrod 13.20 SC	0.08	0.30	0.60	2.0	-	0.90

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 12.24	470	560	+20	130
			0	120
			-20	80
			-29	45
			-40	35
OK Autrod 13.10SC	510	600	-18	100
			-29	70
OK Autrod 13.20SC	540	630	-18	80
			-29	30

Approvals

Wire	ABS	LR	DNV	BV	GL	RS	Ü	DB	VdTÜV
OK Autrod 12.24									x
OK Autrod 13.10 SC								x	x
OK Autrod 13.20 SC									x

Other approvals may be applicable. Please contact ESAB.

Classifications

Wire	EN 756	SFA/AWS A5.23
OK Autrod 12.24	S 42 2 FB S2Mo	F7A4-EA2-A2/F7P2-EA2-A2
OK Autrod 13.10 SC		F8P2-EB2R-B2
OK Autrod 13.20 SC		F8P0-EB3R-B3