

OK Flux 10.70

SAW

Type Basic EN 760: SA AB 1 79 AC

Description

OK Flux 10.70 is specially designed for welding with OK Autrod 12.10 and OK Autrod 12.20 in the butt and fillet welding of mild, medium and high tensile steels with impact requirements down to -20°C. OK Flux 10.70 is of the aluminate basic type and, for this slag system, it has a very high current-carrying capacity on both AC and DC. As it is an alloying flux with significant Si and Mn pick-up, it is most suitable for applications with high base material dilution – in other words, in fillet welding and butt welding with a small number of passes in single- or multi-wire systems.

Density

approx. 1.1 kg/dm³

Basicity index

1.7

Flux consumption, kg flux/kg wire

Voltage	DC+	AC
26	0.65	0.5
30	0.9	0.75
34	1.15	1.0
38	1.45	1.2

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.10	0.05	0.5	1.7	-	-	-
OK Autrod 12.20	0.06	0.6	1.9	-	-	-

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 12.10	430	520	+20	125
			0	100
			-20	70
			-30	55
OK Autrod 12.20	470	580	-40	40
			+20	100
			0	90
			-20	75
			-29	50

Approvals

Wire	ABS	LR	DNV	BV	GL	RS	Ü	DB	VdTÜV
OK Autrod 12.10	3TM, 3YM	3T, 3YM	IIIT (IIITYM)	A3, 3YM, 3T	3TM, 3YM		x	x	x
OK Autrod 12.20							x	x	x

Other approvals may be applicable. Please contact ESAB.

Classifications

Wire	EN 756	SFA/AWS A5.17
OK Autrod 12.10	S 42 3 AB S1	F7A4-EL12/F7P4-EL12
OK Autrod 12.20	S 46 3 AB S2	F7A2-EM12/F7P2-EM12