

OK Flux 10.72

Type Basic

SAW

EN 760: SA AB 1 57 AC

Description

Agglomerated aluminate-basic flux with an extremely high current-carrying capacity, for applications with toughness requirements down to -50°C. Excellent slag removal, also in narrow V-joints. Ideal for structural steels, fine-grained steels and low-temperature steels. Specially designed for windmill tower fabrication. Suitable for single- and multi-wire procedures and for both DC and AC welding. Designed for the single-layer and multi-layer welding of unlimited plate thickness.

Density

1.1 kg/dm³

Basicity index

1.9

Flux consumption, kg flux/kg wire

Voltage	DC+	AC
26	0.7	0.6
30	1.0	0.9
34	1.3	1.2
38	1.5	1.4

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.20	0.05	0.2	1.5	-	-	-
OK Autrod 12.22	0.05	0.3	1.5	-	-	-

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 12.20	415	500	-30	125
			-40	100
			-50	70
			-62	50
OK Autrod 12.22	415	500	-30	120
			-40	100
			-50	70
			-62	50

Approvals

Wire	ABS	LR	DNV	BV	GL	RS	Ü	DB	VdTÜV
OK Autrod 12.20							x	x	x
OK Autrod 12.22							x	x	x

Other approvals may be applicable. Please contact ESAB.

Classifications

Wire	EN 756	SFA/AWS A5.17
OK Autrod 12.20	S 38 5 AB S2	F7A8-EM12/F6P8-EM12
OK Autrod 12.22	S 38 5 AB S2Si	F7A8-EM12K/F6P8-EM12K