

OK Flux 10.83

SAW

Type

Acid

EN 760: SA AR 1 85 AC

Description

An acid, agglomerated flux for the high-speed, single-pass welding of butt, lap and fillets which are well washed and free from undercut, even at speeds in excess of 3 metres per minute. It is primarily used with DC single- and twin-arc wire systems at currents of up to 1300 A. It is recommended for the high-speed welding of heat exchanger tubes, storage tanks, building beams and rail car panels.

Density

≈1.4 kg/dm³

Basicity index

0.3

Flux consumption, kg flux/kg wire

Voltage	DC+	AC
26	0.8	0.5
30	1.1	0.8
34	1.4	1.0
38	1.8	1.4

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.22	0.05	0.8	0.9	-	-	-
OK Autrod 12.51	0.04	1.3	1.3	-	-	-

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 12.22	470	560	+20 0	50 30
OK Autrod 12.51	530	610	+20	25

Approvals

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

Other approvals may be applicable. Please contact ESAB.

Classifications

Wire	EN 756	SFA/AWS A5.17
OK Autrod 12.22	S42 Z AR S2Si	F7AZ-EM12K/F7PZ-EM12K
OK Autrod 12.51	S 46 Z AR SO	F7AZ-EH11K/F7PZ-EH11K