

OK Flux 10.92

SAW

Type Calcium silicate SA CS 2 Cr DC

Description

OK Flux 10.92 is an agglomerated, Cr-alloying flux which is designed for the butt welding of stainless steels. It can also be used for strip cladding with austenitic stainless welding strips. The chromium alloying effect of OK Flux 10.92 compensates for Cr losses in the arc during welding.

Density

approx. 1.0 kg/dm³

Basicity index

1.0

Flux consumption as kg flux/kg wire

Voltage	DC+
26	0.4
30	0.55
34	0.7
38	0.9

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 16.97	0.04	0.9	5.0	19.0	8.5	-
OK Autrod 308H	0.03	0.9	1.0	20.0	10.0	0.75
OK Autrod 308L	0.02	0.9	1.0	20.0	10.0	-
OK Autrod 309L	0.02	0.8	1.1	24.0	13.0	-
OK Autrod 309MoL	0.02	0.5	1.5	21.0	15.0	3.0
OK Autrod 310	0.1	0.8	1.1	26.0	21.0	-
OK Autrod 312	0.1	0.8	1.0	30.0	9.0	-
OK Autrod 316L	0.02	0.8	1.0	19.0	12.0	2.7
OK Autrod 318	0.03	0.5	1.2	18.5	12.0	2.6
OK Autrod 347	0.04	0.8	0.9	20.0	10.0	-
OK Band 308L	0.02	1.0	0.7	20.0	9.5	-
OK Band 309L	0.02	1.2	0.7	23.0	12.5	-
OK Band 316L	0.02	0.9	0.7	18.5	12.3	2.7
OK Band 347	0.03	1.3	0.7	20.0	9.5	-

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 16.97	450	630	+20	60
			-20	55
			-60	45
OK Autrod 308H	365	580	-60	60
OK Autrod 308L	365	580	-60	60
OK Autrod 309L	410	575	-20	50
OK Autrod 309MoL	400	600	+20	120
OK Autrod 316L	385	590	-70	55
OK Autrod 318	440	600	+20	100
			-60	90
			-110	40
OK Autrod 347	470	640	-60	55

Approvals

Wire	ABS	LR	DNV	BV	GL	RS	CL	DB	VdTÜV
OK Autrod 308L							x		x
OK Autrod 347									x
OK Autrod 316L			316 L (tm)				x		x
OK Autrod 317L			316L (tm), NV 25	UP (KV) -60°C)					
OK Autrod 318									x
OK Autrod 309L		SS/CMn	x						
OK Band 308L			x						x
OK Band 347									x
OK Band 316L			x		4462M				x

Classifications

Wire	EN 12072	SFA/AWS A5.9
OK Autrod 308L	ER308L	S 19 9 L
OK Autrod 308H	ER308H	S 19 9 H
OK Autrod 347	ER347	S 19 9 Nb
OK Autrod 316L	ER316L	S 19 12 3 L
OK Autrod 318	ER318	S 19 12 3 Nb
OK Autrod 309L	ER309L	S 23 12 L
OK Autrod 309MoL	(309MoL)	S 23 12
OK Autrod 310	ER310	S 25 20
OK Autrod 312	ER312	S 29 9
OK Autrod 16.97	(ER307)	S 18 8 Mn
OK Band 308L	EQ308L	S 19 9 L
OK Band 347	EQ347	S 19 9 Nb
OK Band 316L	EQ316L	S 19 12 3 L
OK Band 309L	EQ309L	S 23 12 L