

OK Flux 10.96

SAW

Type Neutral

SA CS 3 Cr DC

Description

OK Flux 10.96 is a Cr-alloying agglomerated flux intended for hardfacing with a hardness of up to 40 HRC in combination with mild steel electrodes. OK Flux 10.96 is specifically designed for hardfacing in combination with OK Autrod 12.10, which gives a weld metal hardness of 35-40 HRC.

The flux consumption and the chromium content of the deposit in the weld metal increase with increasing arc voltage. As a result, the hardness and the hardenability of the weld metal also increase as the arc voltage increases. Wheel beds for cranes loading wagons, shafts, caterpillar tracks and links are typical areas of application. Hardfacing with OK Flux 10.96 can be performed on AC or DC. DC positive polarity produces higher heat input to the base material and somewhat higher flux consumption and a lower deposition rate than negative polarity. As the flux contains chromium and the chromium content of the deposit varies with the arc voltage, the latter should be kept as constant as possible.

Density

≈1.1 kg/dm³

Basicity index

0.7

Flux consumption as kg flux/kg wire

Voltage	DC+	AC
30	0.7	0.6
34	0.9	0.8
38	1.2	1.0

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr
OK Autrod 12.10	0.6	1.2	0.85	3.5