

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