

OK Flux 10.93

SAW

Type Fluoride basic

SA AF 2 DC

Description

OK Flux 10.93 is a basic non-alloying agglomerated flux for the submerged arc welding of stainless steels and high-alloyed CrNiMo steels such as duplex stainless steels.

Density

~1.0 kg/dm³

Basicity index

1.7

Flux consumption as kg flux/kg wire

Voltage	DC+
26	0.5
30	0.6
34	0.8
38	1.0

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 308L	0.03	0.6	1.4	20.0	10.0	-
OK Autrod 309L	0.03	0.6	1.5	24.0	12.5	-
OK Autrod 312	0.1	0.5	1.5	29.0	9.5	-
OK Autrod 316L	0.03	0.6	1.4	18.5	11.5	2.7
OK Autrod 318	0.04	0.6	1.2	18.5	12.0	2.6
OK Autrod 347	0.03	0.5	1.1	19.2	9.6	-
OK Autrod 385	0.03	0.6	1.5	19.0	25.0	4.0
OK Autrod 16.97	0.06	1.2	6.3	18.0	8.0	-
OK Autrod 2209	0.02	0.8	1.3	22.0	9.0	-

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 308L	400	560	-40	75
			-60	65
			-110	55
			-196	40
OK Autrod 309L	430	570	-60	70
			-110	60
			-196	35
OK Autrod 316L	390	565	-40	95
			-60	90
			-110	75
			-196	40
OK Autrod 318	440	600	-60	90
			-110	40
OK Autrod 347	455	635	-60	85
			-110	60
			-196	30
OK Autrod 385	310	530	+20	80
OK Autrod 2209	630	780	-20	125
			-40	110
			-60	80