

OK Flux 10.92

OK Flux 10.92 is an neutral, agglomerated Cr-compensating flux designed for strip cladding, butt and fillet welding of stainless and corrosion resistant steel types. Good welding characteristics and easy slag removal.

Классификации	EN ISO 14174 : S A CS 2 57 53 DC
Сварочный ток	1200 A
Тип шлака	Calcium silicate SiO ₂ -MgO-Al ₂ O ₃ -(CaF ₂)
Перенос легирующего элемента	Chromium compensating
Плотность	nom 1.0 kg/dm ³
Показатель щелочности	nom 1.0

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.4 kg	-
30 V	0.55 kg	-
34 V	0.7 kg	-
38 V	0.9 kg	-

Dimensions	Amps	Travel Speed
4.0 mm	580 A	33 m/h

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
OK Autrod 16.97	14343-A:S 18 8 Mn	
OK Autrod 308L	A5.9:ER308L/ 14343-A:S 19 9 L	
OK Autrod 309L	A5.9:ER309L/ 14343-A:S 23 12 L	A5.39: F85A4-ER309L/309L
OK Autrod 309L	A5.9:ER309L/ 14343-A:S 23 12 L	A5.39: F85A4-ER309L/309L
OK Autrod 316L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F80A10-ER316L/316L
OK Autrod 316L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F80A10-ER316L/316L
OK Autrod 318	A5.9:ER318/ 14343-A:S 19 12 3 Nb	
OK Autrod 347	A5.9:ER347/ 14343-A:S 19 9 Nb	

Approvals

Combined with Wire	VdTÜV
OK Autrod 308L	•
OK Autrod 316L	•
OK Autrod 318	•
OK Autrod 347	•

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 16.97	As Welded DC+ hr	450 MPa	630 MPa	42 %	60 J @ 20°C 55 J @ -20°C 45 J @ -60°C
OK Autrod 308L	As Welded DC+ hr	365 MPa	580 MPa	38 %	60 J @ -60°C 50 J @ -110°C
OK Autrod 309L	As Welded DC+ hr	420 MPa	560 MPa	32 %	40 J @ -20°C
OK Autrod 309L	As Welded DC+ hr	440 MPa	600 MPa	30 %	55 J @ -20°C 50 J @ -40°C
OK Autrod 316L	As Welded DC+ hr	385 MPa	590 MPa	36 %	55 J @ -70°C
OK Autrod 316L	As Welded DC+ hr	415 MPa	570 MPa	32 %	55 J @ -70°C
OK Autrod 318	As Welded hr	440 MPa	600 MPa	42 %	100 J @ 20°C 90 J @ -60°C 40 J @ -110°C
OK Autrod 347	As Welded DC+	470 MPa	640 MPa	35 %	65 J @ 20°C 55 J @ -60°C 40 J @ -110°C

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Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
OK Autrod 16.97									
0.04	5.0	0.95	0.01	0.02	8.5	18.8	0.1	-	-
OK Autrod 308L Current: DC+, 420A, 27V									
0.02	1.0	0.9	-	-	10.0	20.0	-	-	-
OK Autrod 309L 2.4mm, DC+, 400A, 28V, 50 cm/min									
0.02	1.2	0.7	0.01	0.02	12.9	22.6	0.04	0.01	0.08
OK Autrod 316L 2.4mm: DC+, 400A, 28V, 50 cm/min.									
0.02	1.1	0.7	0.01	0.02	11.6	18.1	2.5	0.15	0.05
OK Autrod 318									
0.035	1.2	0.5	-	-	12.0	18.5	2.6	0.2	-
OK Autrod 347 Current: DC+, 420 A, 27 V									
0.040	0.9	0.75	-	-	9.7	19.8	-	-	-

Nb	FN WRC-92
OK Autrod 16.97	
-	-
OK Autrod 308L Current: DC+, 420A, 27V	
-	-
OK Autrod 309L 2.4mm, DC+, 400A, 28V, 50 cm/min	
-	7
OK Autrod 316L 2.4mm: DC+, 400A, 28V, 50 cm/min.	
0.01	7
OK Autrod 318	
0.3	-
OK Autrod 347 Current: DC+, 420 A, 27 V	
0.5	9