

OK Flux 10.11

Very high basic agglomerated flux for electro slag strip cladding.

The flux has a low viscosity and is suitable for cladding with Ni base, Co and fully austenitic alloys due to its good wetting behaviour.

Also suitable for welding with higher travel speeds.

Классификации	EN ISO 14174 : ES A FB 2B 56 44 DC
Сварочный ток	approx. 2500 (90 x 0.5 mm strip)
Тип шлака	Fluoride basic CaF ₂ -Al ₂ O ₃
Перенос легирующего элемента	Moderately silicon alloying
Плотность	nom 1.0 kg/dm ³
Показатель щелочности	nom 5.4

Classifications

Wire	SFA/AWS - EN ISO
OK Band NiFeCr1	A5.14:EQNiFeCr-1/ 18274:B Ni 8065 (NiFe30Cr21Mo3)

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
OK Band NiFeCr1 Strip dimensions: 60x0.5mm.									
Parameters: 1250A, 24V, 18cm/min.									
Stick-out 30mm.									
0.018	0.5	0.85	0.001	0.015	38.5	20.0	2.9	0.03	1.8
OK Band NiFeCr1 Strip dimensions: 60x0.5mm. Parameters: 1250A, 24V, 18cm/min. Stick-out 30mm.									
0.017	0.5	0.85	0.001	0.015	39.5	20.5	3.0	0.03	1.9

Ti	Fe
OK Band NiFeCr1 Strip dimensions: 60x0.5mm.	
Parameters: 1250A, 24V, 18cm/min.	
Stick-out 30mm.	
0.1	31.0
OK Band NiFeCr1 Strip dimensions: 60x0.5mm. Parameters: 1250A, 24V, 18cm/min. Stick-out 30mm.	
0.1	28.0