

OK Flux 10.71

SAW

OK Flux 10.71 is a basic, agglomerated, slightly Si- an Mn-alloying flux for submerged arc welding, specially designed for fillet welding and for the single and multi-pass butt welding of mild, medium and high tensile steels. OK Flux 10.71 is of the aluminate-basic type and for this slag system, it has a very high current-carrying capacity on both AC and DC and very good operating characteristics. It is very suitable for narrow gap welding due to the excellent slag detachability and smooth sidewall blending.

DENSITY	BASICITY INDEX
Approx. 1.2 kg/dm ³	1.6

PACKING/ORDERING INFORMATION		
Part Number	Package Weight (kg)	Pallet Weight (kg)
1071000N00	25	1000

TYPICAL MECH. PROPERTIES OF ALL WELD METAL				
WIRE	YIELD STRESS MPa	TENSILE STRENGTH MPa	CHARPY V	
			°C	J
OK Autrod 12.10	360	465	0	125
			-20	95
			-30	75
			-40	65
			+20	135
OK Autrod 12.20	425	510	0	125
			-20	80
			-40	55
			+20	150
			0	140
OK Autrod 12.22	425	520	-20	100
			-40	60
			-46	40
			+20	150
			0	130
OK Autrod 12.32	480	580	-20	95
			-40	65
			-46	40
			+20	125
			0	100
OK Autrod 12.24	500	580	-20	60
			-40	30
			+20	120
			0	105
			-20	70
OK Autrod 12.34	535	620	-30	60
			-40	45
			+20	120
			-20	85
			-30	70
OK Autrod 13.24	560	630	-40	60
			-46	40

FLUX CONSUMPTION AS KG FLUX/KG WIRE		
VOLTAGE	DC+	AC
26	0.6	0.5
30	0.85	0.7
34	1.15	0.95
38	1.35	1.15

TYPICAL PROPERTIES OF ALL WELD METAL						
WIRE	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.10	0.04	0.30	1.0	-	-	-
OK Autrod 12.20	0.05	0.30	1.35	-	-	-
OK Autrod 12.22	0.05	0.50	1.4	-	-	-
OK Autrod 12.24	0.05	0.40	1.4	-	-	0.5
OK Autrod 12.32	0.10	0.35	2.0	-	-	-
OK Autrod 12.34	0.10	0.40	1.6	-	-	0.5
OK Autrod 13.24	0.07	0.50	1.45	-	0.9	0.2

APPROVALS									
WIRE	ABS	LR	DNV	BV	GL	RS	U	DB	VdTUV
OK Autrod 12.10	3M	3M	IIIM	A3M	3M	-	X	X	X
OK Autrod 12.20	3M, 3YM	3M, 3YM	IIIM	3YM	3YM	-	X	X	X
OK Autrod 12.22	4Y400M	4Y40M	IVY40M	A 4Y40M	4Y40M	-	X	X	X
OK Autrod 12.24	3TM3YTM	3T3YM	IIITYM	A3, A3YTM	3YTM	3YTM	X	X	X

CLASSIFICATIONS OF WELD METAL			
WIRE	EN 756	SFA/AWS A5.17	SFA/AWS A5.23
OK Autrod 12.10	S 35 4 AB S1	F6A4-EL12/F6P5-EL12	-
OK Autrod 12.20	S 38 4 AB S2	F7A4-EM12/F6P4-EM12	-
OK Autrod 12.22	S 38 4 AB S2Si	F7A5-EM12K/F6P5-EM12K	-
OK Autrod 12.32	S 46 4 AB S3Si	F7A5-EH12K/F7P5-EH12K	-
OK Autrod 12.24	S 46 2 AB S2Mo	-	F8A2-EA2-A4/F7P0-EA2-A4
OK Autrod 12.34	S 50 3 AB S3Mo	-	F8A4-EA4-A3/F8P2-EA4-A3
OK Autrod 13.24	S 50 4 AB S0	-	F8A5-EG-G/F8P4-EG-G