



OK Flux 10.62

SAW

OK Flux 10.62 is an all-mineral, non-alloying, high-basic flux. The weld metal can be fully controlled through the suitable choice of wires, independently of the welding parameters. It is therefore very suitable for the multi-run welding of thick materials using the single-wire and multiple-wire technique. It is designed for the multi-pass butt welding of mild, medium and high tensile steels, as well as low-alloyed steels, with an impact strength down to $-40^{\circ}\text{C}/-60^{\circ}\text{C}$. As it is a flux of the high-basic type, OK Flux 10.62 has a high current-carrying capacity on both AC and DC. To increase productivity with no loss of mechanical properties, OK Flux 10.62 is best used together with iron powder addition. It is especially suitable for narrow gap welding, due to the good slag detachability and smooth sidewall blending. Pressure vessels for nuclear applications and offshore constructions in which good CTOD values are required are two areas in which OK Flux 10.62 can be successfully used. It operates optimally at the lower end of the voltage range, yields low-oxygen weld metal (approx. 300 ppm) and produces low-hydrogen weld metal (lower than 5ml/100g).

DENSITY	BASICITY INDEX
Approx. 1.1 kg/dm ³	3.4

PACKING/ORDERING INFORMATION		
Part Number	Package Weight (kg)	Pallet Weight (kg)
1062000N00	25	1000

TYPICAL MECH. PROPERTIES OF ALL WELD METAL				
WIRE	YIELD STRESS Mpa	TENSILE STRENGTH Mpa	CHARPY V	
			°C	J
OK Autrod 12.22	410	500	0	170
			-20	160
			-40	90
			-50	70
			-62	35
OK Autrod 12.24	500	580	+20	140
			0	115
			-20	80
			-40	60
			-51	45
OK Autrod 12.32	475	570	+20	175
			0	150
			-30	130
			-40	110
			-62	70
OK Autrod 12.34	540	620	+20	170
			0	160
			-20	140
			-40	115
			-51	45
OK Autrod 12.40	530	620	+20	140
			0	110
			-20	80
			-40	50
			-51	40
OK Autrod 13.10 SC (Stress relieved 690°C 1h)	500	610	-18	110
OK Autrod 13.40	650	730	-40	70
			-50	60
			-62	50
OK Autrod 13.43	700	795	-20	100
			-40	75
			-50	65
			-60	55
			-62	50

FLUX CONSUMPTION AS KG FLUX/KG WIRE		
VOLTAGE	DC+	AC
26	0.7	0.6
30	0.9	0.75
34	1.2	1.0
38	1.5	1.25

TYPICAL PROPERTIES OF ALL WELD METAL						
WIRE	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.22	0.07	0.30	1.0	-	-	-
OK Autrod 12.24	0.07	0.22	1.0	-	-	0.5
OK Autrod 12.32	0.10	0.35	1.6	-	-	-
OK Autrod 12.34	0.10	0.21	1.45	-	-	0.5
OK Autrod 12.40	0.08	0.12	1.9	-	-	-
OK Autrod 13.10 SC	0.08	0.21	0.7	-	-	0.5
OK Autrod 13.40	0.07	0.26	0.7	1.1	0.9	0.5
OK Autrod 13.43	0.08	0.25	1.35	0.6	2.2	0.5

APPROVALS									
WIRE	ABS	LR	DNV	BV	GL	RS	U	DB	VdTUV
OK Autrod 12.22	3M, 3YM	3M, 3YM	IIIM	A3, 3YM	3YM	-	X	X	X
OK Autrod 12.24	-	-	-	A3, 3YM	-	-	-	-	-
OK Autrod 12.32	4YQ420M	4Y40MH5	IVY42M	A4Y42M	4Y42M	4Y42M	X	X	X
OK Autrod 12.34	4YQ500M	3M, 3YM	III YM	A4Y50M	4Y50M	4Y50M	-	-	-
OK Autrod 13.10 SC	-	-	-	-	-	-	-	X	X
OK Autrod 13.40	4YQ620M	-	-	-	-	-	-	-	X
OK Autrod 13.43	4YQ690M	4Y69M	IV Y69M	4Y69M	4Y69M	-	-	-	-

CLASSIFICATIONS OF WELD METAL			
WIRE	EN 756	SFA/AWS A5.17	SFA/AWS A5.23
OK Autrod 12.22	S 38 5 FB S2Si	F7A8-EM12K/F6P8-EM12K	-
OK Autrod 12.24	S 46 4 FB S2Mo	-	F8A6-EA2-A2/F7P6-EA2-A2
OK Autrod 12.32	S 46 6 FB S3Si	F7A8-EH12K/F7P8-EH12K	-
OK Autrod 12.34	S 50 4 FB S3Mo	-	F8A6-EA4-A4/F8P6-EA4-A4
OK Autrod 12.40	S 50 4 FB S4	F7A6-EH14/F7P6-EH14	-
OK Autrod 13.10 SC	-	-	F8P2-EB2R-B2
OK Autrod 13.40	S 62 6 FB S3Ni1Mo	-	F10A8-EG-F3/F9P6-EG-F3
OK Autrod 13.43	S 69 6 FB S3Ni2 5CrMo	-	F11A8-EG-G/F11P8-EG-G

