

OK Flux 10.62

SAW

Type High-basic EN 760: SA FB 1 55 AC H5

Description

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. OK Flux 10.62 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°/-60°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. OK Flux 10.62 is especially suitable for narrow gap welding, due to the good slag detachability and smooth side-wall 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.

OK Flux 10.62 yields low-oxygen weld metal (approx. 300 ppm) and produces low-hydrogen weld metal (lower than 5 ml/100 g).

Density

approx. 1.1 kg/dm³

Basicity index

3.4

Flux consumption, 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 all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.22	0.07	0.30	1.0	-	-	-
OK Autrod 12.32	0.10	0.35	1.6	-	-	-
OK Autrod 12.32/ OK Grain 21.85	0.10	0.4	1.6	-	-	-
OK Autrod 12.40	0.08	0.12	1.9	-	-	-

Typical mech. properties 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 12.32	475	570	+20	175
			0	150
			-30	130
			-40	110
			-62	70
OK Autrod 12.32/ OK Grain 21.85	475	540	-40	110
			-60	75
OK Autrod 12.40	530	620	+20	140
			0	110
			-20	80
			-40	50
			-51	40

Approvals

Wire	ABS	LR	DNV	BV	GL	RS	Ü	DB	VdTÜV
OK Autrod 12.22	3M, 3YM	3M, 3YM	IIIYM	A3, 3YM	3YM		x	x	x
OK Autrod 12.32	4Y42M	4Y40M	IVY42M	A4Y42M	4Y42M	3YM	x	x	x

Other approvals may be applicable. Please contact ESAB.

Classifications

Wire	EN 756	SFA/AWS A5.17
OK Autrod 12.22	S 38 5 FB S2Si	F7A8-EM12K/F6P8-EM12K
OK Autrod 12.32	S 46 6 FB S3Si	F7A8-EH12K/F7P8-EH12K
OK Autrod 12.40	S 50 4 FB S4	F7A6-EH14/F7P6-EH14

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