

OK Flux 10.16

High basic, all mineral, agglomerated flux designed for welding nickel and nickel based alloys. The flux is particularly suitable for strip cladding with Ni-based strip. The silicon transfer from the flux to the weld metal is strongly reduced by the well balanced flux composition and thus minimizing the risk for hot cracking in welding Ni-based alloys.

Classifications	EN ISO 14174 : S A FB 2 55 43 DC
Approvals	NAKS/HAKC RD 03-613-03

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	900 A (60 x 0.5 mm strip)
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Alloy Transfer	Moderately manganese and silicon alloying
Density	nom 1.2 kg/dm ³
Basicity Index	nom 2.4

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
OK Autrod NiCr-3	A5.14:ERNiCr-3/ 18274:S Ni 6082 (NiCr20Mn3Nb)	
OK Autrod NiCrMo-13	A5.14:ERNiCrMo-13/ 18274:S Ni 6059 (NiCr23Mo16)	
OK Autrod NiCrMo-3	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr22Mo9Nb)	A5.39: F100A32-ERNiCrMo-3/NiCrMo-3
OK Autrod NiCrMo-3	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr22Mo9Nb)	A5.39: F100A32-ERNiCrMo-3/NiCrMo-3
OK Autrod NiCrMo-3 SAW	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr22Mo9Nb)	
OK Band NiCrMo3	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)	

Approvals

Combined with Wire	vdtÜV
OK Band NiCr3	•

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod NiCr-3	As Welded 325A DC+ Feed speed: 25m/h hr	360 MPa	600 MPa	41 %	140 J @ 20°C 100 J @ -196°C
OK Autrod NiCrMo-13	As Welded 300A DC+ Feed speed: 25m/h hr	490 MPa	730 MPa	44 %	80 J @ 20°C 75 J @ -60°C 60 J @ -196°C
OK Autrod NiCrMo-3	As Welded HI ~1.0-1.7 kJ/mm DC+ hr	450 MPa	720 MPa	38 %	100 J @ -140°C 90 J @ -196°C
OK Autrod NiCrMo-3	As Welded HI ~1.0-1.7 kJ/mm DC+ hr	450 MPa	720 MPa	43 %	100 J @ -140°C 90 J @ -196°C
OK Autrod NiCrMo-3	As Welded HI ~1.0-1.7 kJ/mm DC+	450 MPa	720 MPa	50 %	110 J @ -140°C 100 J @ -196°C
OK Autrod NiCrMo-3 SAW	As Welded HI ~1.0-1.7 kJ/mm DC+ hr	450 MPa	720 MPa	43 %	100 J @ -140°C 90 J @ -196°C