

OK Flux 10.62 (Advanced Slag Release)

Improved OK Flux 10.62 with excellent slag detachability and very strong grains. Creates very smooth weld beads, soft transitions to side walls and concave weld bead profiles. Can be used with high parameters and all SAW process variants such as Tandem, Twin, ICE, 3 or 4 wire process in every multi pass joint including narrow gap. The strong grains allow multiple recycling cycles and prolonged flux hopper refilling intervals. Disturbances during flux recycling and dust creation are minimized. Flux chemistry, mechanical values and classifications for flux and all combinations same as for OK Flux 10.62, thus with various wires for highest demands on impact properties, low temperature toughness, strength and CTOD-values. For Offshore constructions, pressure vessels, power generation, shipbuilding, pipe mills, civil constructions, transport industries, etc. Produces weld metal with hydrogen contents maximum 5 ml/100 g, in BlockPac (moisture protection) maximum 4 ml/100g.

Classifications	EN ISO 14174 : S A FB 1 55 AC H5 EN ISO 14174 : S A FB 1 55 AC H4 only BlockPac/moisture-protection
Approvals	CE EN 13479 DB 51.039.07 NAKS/HAKC RD 03-613-03

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

Diffusible Hydrogen	max 5 ml H/100g weld metal (Redried flux); max 4 ml H/100g in BlockPac (moisture protection)
Slag Type	Fluoride-basic
Alloy Transfer	No Silicon or Manganese alloying
Density	nom 1.1 kg/dm ³
Basicity Index	nom 3.2

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.7 kg	0.6 kg
30 V	1.0 kg	0.9 kg
34 V	1.3 kg	1.2 kg
38 V	1.6 kg	1.4 kg

Dimensions	Amps	Travel Speed
Ø 4.0 mm	580 A	55 cm/min

Classifications

Wire	SFA/AWS - EN ISO	EN - As Welded	AWS - As Welded	AWS - PWHT
OK Autrod 12.22	A5.17:EM12K/ 14171-A:S2Si	14171-A: S 38 5 FB S2Si	A5.17: F7A8-EM12K	A5.17: F6P8-EM12K
OK Autrod 12.24	A5.23:EA2/ 14171-A:S2Mo; 24598-A:S S Mo	14171-A: S 46 4 FB S2Mo	A5.23: F8A6-EA2-A2	A5.23: F8P6-EA2-A2
OK Autrod 12.32	A5.17:EH12K/ 14171-A:S3Si	14171-A: S 46 6 FB S3Si	A5.17: F7A8-EH12K	A5.17: F7P8-EH12K
OK Autrod 12.34	A5.23:EA4/ 14171-A:S3Mo; 24598-A:S S MnMo	14171-A: S 50 4 FB S3Mo	A5.23: F8A6-EA4-A4	A5.23: F8P6-EA4-A4
OK Autrod 12.40	A5.17:EH14/ 14171-A:S4	14171-A: S 50 4 FB S4	A5.17: F7A6-EH14	A5.17: F7P6-EH14
OK Autrod 12.44	A5.23:EA3/ 24598-B:SU 4M3		A5.23: F9A8-EA3-A3	A5.23: F9P8-EA3-A3
OK Autrod 13.10 SC	A5.23:EB2R/ 24598-A:S S CrMo1			A5.23: F8P2-EB2R-B2
OK Autrod 13.20 SC	A5.23:EB3R/ 24598-A:S S CrMo2			A5.23: F8P2-EB3R-B3
OK Autrod 13.21	A5.23:ENi1/ 14171-A:S2Ni1	14171-A: S 42 4 FB S2Ni1	A5.23: F7A6-ENi1-Ni1	A5.23: F7P8-ENi1-Ni1
OK Autrod 13.24	A5.23:ENi6/ 14171-A: S3Ni1Mo0,2	14171-A: S 50 6 FB S3Ni1Mo0,2	A5.23: F8A10-ENi6-Ni6	A5.23: F8P8-ENi6-Ni6
OK Autrod 13.27	A5.23:ENi2/ 14171-A:S2Ni2	14171-A: S 46 7 FB S2Ni2	A5.23: F7A10-ENi2-Ni2	A5.23: F7P10-ENi2-Ni2
OK Autrod 13.40	A5.23:EG/ 14171-A:S3Ni1Mo; 26304-A:S3Ni1Mo; 26304-B: (SUN2M2)	26304-A: S 62 6 FB S3Ni1Mo (AC)	A5.23: F10A8-EG-F3 (AC)	A5.23: F9P8-EG-F3
OK Autrod 13.43	A5.23:EG/ 26304-A: S3Ni2,5CrMo; 26304-B: (SUN4C1M3)	26304-A: S 69 6 FB S3Ni2,5CrMo	A5.23: F11A8-EG-G	A5.23: F11P8-EG-G
OK Autrod 13.44	A5.23:EG/ 26304-A: S3Ni1,5CrMo	26304-A: S 62 5 FB S3Ni1,5CrMo	A5.23: F9A8-EG-G	
OK Autrod 13.49	A5.23:ENi3/ 14171-A:S2Ni3	14171-A: S 46 8 FB S2Ni3	A5.23: F8A15-ENi3-Ni3	A5.23: F8P15-ENi3-Ni3

OK Flux 10.62 (Advanced Slag Release)

Approvals

Combined with Wire	ABS	BV	DNV	GL	LR	DB	CE	RINA	RS	VdTÜV
OK Autrod 12.22	•	•	•	•	•	•	•	-	-	•
OK Autrod 12.24	-	-	-	-	-	-	•	-	-	•
OK Autrod 12.32	•	•	•	•	•	•	•	•	•	•
OK Autrod 12.34	•	•	•	•	•	-	-	-	•	-
OK Autrod 13.10 SC	-	-	-	-	-	•	•	-	-	•
OK Autrod 13.20 SC	-	-	-	-	-	-	•	-	-	•
OK Autrod 13.24	•	•	•	•	•	-	•	-	-	-
OK Autrod 13.27	•	•	•	•	•	•	•	•	•	•
OK Autrod 13.43	•	•	•	•	•	-	•	-	-	-
OK Tubrod 15.27S	•	-	•	•	•	-	•	-	-	-

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.22	As Welded AWS DC+	410 MPa	500 MPa	33 %	170 J @ 0°C 160 J @ -20°C 90 J @ -40°C 70 J @ -50°C 35 J @ -62°C
OK Autrod 12.24	As Welded AWS DC+	500 MPa	580 MPa	25 %	140 J @ 20°C 115 J @ 0°C 80 J @ -20°C 60 J @ -40°C 45 J @ -51°C
OK Autrod 12.32	As Welded AWS DC+	475 MPa	560 MPa	28 %	175 J @ 20°C 150 J @ 0°C 130 J @ -30°C 110 J @ -40°C 70 J @ -62°C
OK Autrod 12.34	As Welded AWS DC+	540 MPa	620 MPa	24 %	170 J @ 20°C 160 J @ 0°C 140 J @ -20°C 115 J @ -40°C 45 J @ -51°C
OK Autrod 12.40	As Welded AWS DC+	530 MPa	620 MPa	26 %	140 J @ 20°C 110 J @ 0°C 80 J @ -20°C 50 J @ -40°C 40 J @ -51°C
OK Autrod 12.44	As Welded AWS DC+	600 MPa	700 MPa	27 %	105 J @ -20°C 80 J @ -40°C 65 J @ -50°C 50 J @ -62°C
OK Autrod 13.21	As Welded AWS DC+	470 MPa	560 MPa	28 %	195 J @ 20°C 185 J @ 0°C 160 J @ -20°C 70 J @ -40°C 60 J @ -51°C
OK Autrod 13.24	As Welded AWS DC+	530 MPa	620 MPa	25 %	120 J @ -40°C 110 J @ -50°C 70 J @ -60°C 50 J @ -73°C
OK Autrod 13.27	As Welded AWS DC+	460 MPa	570 MPa	28 %	140 J @ -20°C 110 J @ -40°C 80 J @ -60°C 50 J @ -73°C
OK Autrod 13.40	As Welded AWS DC+	610 MPa	690 MPa	24 %	90 J @ -40°C 80 J @ -50°C 50 J @ -62°C
OK Autrod 13.40	As Welded EN DC+	620 MPa	700 MPa	23 %	100 J @ -40°C 80 J @ -50°C 60 J @ -60°C 50 J @ -62°C
OK Autrod 13.43	As Welded AWS DC+	700 MPa	800 MPa	21 %	100 J @ -20°C 75 J @ -40°C 65 J @ -50°C 50 J @ -62°C
OK Autrod 13.44	As Welded AWS DC+	610 MPa	700 MPa	22 %	95 J @ 0°C 80 J @ -20°C 55 J @ -40°C 40 J @ -62°C
OK Autrod 13.49	As Welded AWS DC+	500 MPa	600 MPa	27 %	95 J @ -70°C 40 J @ -101°C

OK Flux 10.62 (Advanced Slag Release)

Typical Weld Metal Analysis %			
C	Mn	Si	Ni
OK Autrod 12.22 AC, 580 A, 29 V			
0.10	0.95	0.27	-
OK Autrod 12.22 DC+, 580 A, 29 V			
0.07	1.0	0.30	-
OK Autrod 12.40 AC, 580A, 29V			
0.12	1.85	0.10	-
OK Autrod 12.40 DC+, 580A, 29V			
0.08	1.9	0.12	-
OK Autrod 13.21 AC, 580A, 29V			
0.08	0.95	0.22	0.9
OK Autrod 13.21 DC+, 580A, 29V			
0.06	1.0	0.25	0.9
OK Autrod 13.49 AC, 580A, 29V			
0.08	0.95	0.20	3.1
OK Autrod 13.49 DC+, 580A, 29V			
0.06	1.0	0.25	3.1