

## OK Flux 10.94

Basic, chromium-compensating, agglomerated flux for butt welding of stainless steels. Specially recommended for welding of stainless steels of the super duplex type. Low Si addition during welding provides good mechanical properties in the weld metal.

<b>Clasificaciones</b>	EN ISO 14174 : S A AF 2 56 64 DC
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<b>Tipo de escoria</b>	Fluoride basic CaF <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> -SiO <sub>2</sub>
<b>Transferencia de aleación</b>	Chromium compensating
<b>Densidad</b>	nom 1.0 kg/dm <sup>3</sup>
<b>Índice de basicidad</b>	nom 1.9

### Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.5 kg	-
30 V	0.6 kg	-
34 V	0.8 kg	-
38 V	1.0 kg	-

Dimensions	Amps	Travel Speed
4.0 mm	580 A	33 m/h

### Classifications

Wire	SFA/AWS - EN ISO
OK Autrod 2509	A5.9:ER2594/ 14343-A:S 25 9 4 N L
OK Autrod 308L	A5.9:ER308L/ 14343-A:S 19 9 L
OK Autrod 347	A5.9:ER347/ 14343-A:S 19 9 Nb

### Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 2509	As Welded DC+	625 MPa	830 MPa	28 %	90 J @ 20°C 50 J @ -60°C
OK Autrod 308L	As Welded DC+	400 MPa	560 MPa	40 %	85 J @ 20°C 70 J @ -40°C 60 J @ -60°C
OK Autrod 347	As Welded DC+	455 MPa	620 MPa	38 %	100 J @ 20°C 70 J @ -60°C 50 J @ -110°C 30 J @ -196°C

### à% Análisis metal depositado (valores típicos)

C	Mn	Si	Ni	Cr	Mo	Cu	N	Nb	FN WRC-92
<b>OK Autrod 2509 Current: DC+, 420A, 27V</b>									
0.02	0.4	0.5	10.1	24.5	3.5	-	0.15	-	54
<b>OK Autrod 308L DC+</b>									
0.02	1.4	0.5	9.5	20	0.2	0.1	-	-	-
<b>OK Autrod 347 DC+</b>									
0.04	1.0	0.5	9.6	19.6	-	-	-	0.5	-