

OK Flux 10.71

SAW

Type Basic EN 760: SA AB 1 67 AC H5

Description

OK Flux 10.71 is a basic agglomerated, slightly Si- and Mn-alloying flux for submerged arc welding, specially designed for fillet welding and for the single- and multi-pass butt welding of mild, medium and high tensile steels. OK Flux 10.71 is of the aluminate basic type and, for this slag system, it has a very high current-carrying capacity on both AC and DC and very good operating characteristics. OK Flux 10.71 is ideally suited to narrow gap welding due to the excellent slag detachability and smooth side-wall blending.

Density

approx. 1.2 kg/dm³

Basicity index

1.6

Flux consumption, kg flux/kg wire

Voltage	DC+	AC
26	0.6	0.5
30	0.85	0.7
34	1.15	0.95
38	1.35	1.15

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.10	0.04	0.3	1.0	-	-	-
OK Autrod 12.20	0.05	0.3	1.35	-	-	-
OK Autrod 12.22	0.08	0.5	1.4	-	-	-
OK Autrod 12.30	0.09	0.4	1.65	-	-	-
OK Autrod 12.32	0.09	0.5	2.0	-	-	-

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 12.10	360	465	0	125
			-20	95
			-30	75
			-40	65
OK Autrod 12.20	410	510	+20	135
			0	125
			-20	80
			-40	55
OK Autrod 12.22	425	520	+20	150
			0	140
			-20	100
			-40	60
OK Autrod 12.30	480	580	+20	130
			0	110
			-20	90
			-30	60
OK Autrod 12.32	480	580	+20	150
			0	130
			-20	95
			-40	65
			-46	40

Approvals

Wire	ABS	LR	DNV	BV	GL	RS	Ü	DB	VdTÜV
OK Autrod 12.10	3M	3M	IIIM	A3M	3M		x	x	x
OK Autrod 12.20	3M, 3YM	3M, 3YM	IIIM	3YM	3YM		x	x	x
OK Autrod 12.22	4Y400M	4Y40M	IVY40M	A 4Y40M	4Y40M		x	x	x
OK Autrod 12.30							x	x	x

Other approvals may be applicable. Please contact ESAB.

Classifications

Wire	EN 756	SFA/AWS A5.17
OK Autrod 12.10	S 35 4 AB S1	F6A4-EL12/F6P5-EL12
OK Autrod 12.20	S 38 4 AB S2	F7A4-EM12/F6P4-EM12
OK Autrod 12.22	S 38 4 AB S2Si	F7A5-EM12K/F6P5-EM12K
OK Autrod 12.30	S 46 3 AB S3	
OK Autrod 12.32	S 46 4 AB S3Si	F7A5-EH12K//F7P5-EH12K