

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 very suitable for 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 12.24 | 0.05 | 0.4 | 1.35 | | | 0.5 |
| OK Autrod 12.34 | 0.09 | 0.4 | 1.5 | | | 0.5 |
| OK Autrod 13.24 | 0.07 | 0.5 | 1.5 | | 0.9 | 0.2 |
| OK Autrod 13.27 | 0.05 | 0.4 | 1.4 | | 2.2 | - |
| | | | | | | Cu: |
| OK Autrod 13.36 | 0.08 | 0.5 | 1.3 | 0.3 | 0.7 | 0,5 |

Typical mech. properties all weld metal

| Wire | Yield stress MPa | Tensile strength MPa | Charpy V °C | J |
|-----------------|------------------|----------------------|-------------|-----|
| OK Autrod 12.24 | 500 | 580 | +20 | 125 |
| | | | 0 | 100 |
| | | | -20 | 60 |
| | | | -40 | 30 |
| OK Autrod 12.34 | 535 | 620 | +20 | 120 |
| | | | 0 | 105 |
| | | | -20 | 70 |
| | | | -30 | 60 |
| | | | -40 | 45 |
| OK Autrod 13.24 | 560 | 630 | +20 | 120 |
| | | | -20 | 85 |
| | | | -30 | 70 |
| | | | -40 | 60 |
| | | | -46 | 40 |
| OK Autrod 13.27 | 500 | 600 | -20 | 100 |
| | | | -40 | 60 |
| | | | -51 | 50 |
| OK Autrod 13.36 | 490 | 580 | +20 | 120 |
| | | | -20 | 70 |
| | | | -29 | 55 |

Approvals

| Wire | ABS | LR | DNV | BV | GL | RS | Ü | DB | VdTÜV |
|-----------------|------|----------|--------|-------|------|----|---|----|-------|
| OK Autrod 12.24 | 3TM | 3T, 3YM, | IIITYM | A3, | 3YTM | | | x | x |
| | 3YTM | 3YT | | A3YTM | | | | | |
| OK Autrod 12.34 | | | | | | | | | |
| OK Autrod 13.24 | | | | | | | | | |
| OK Autrod 13.27 | | | | | | | | | x |
| OK Autrod 13.36 | | | | | | | | | |

Classifications

| Wire | EN 756 | SFA/AWS A5.23 |
|-----------------|-------------------|-----------------------------|
| OK Autrod 12.24 | S 46 2 AB S2Mo | F8A2-EA2-A4/F7P0-EA2-A4 |
| OK Autrod 12.34 | S 50 3 AB S3Mo | F8A4-EA4-A3/F8P2-EA4-A3 |
| OK Autrod 13.24 | S 50 4 AB S0 | F8A5-EG-G/F8P4-EG-G |
| OK Autrod 13.27 | S 46 5 AB S2Ni2 | F8A6-ENi2-Ni2/F7P6-ENi2-Ni2 |
| OK Autrod 13.36 | S 46 3 AB S2Ni1Cu | F8A2-EG-G |