

OK Flux 10.72

SAW

Type Aluminate-basic

EN 760: SA AB 1 57 AC

Description

Agglomerated, aluminate-basic flux with an extremely high current-carrying capacity, for applications with toughness requirements down to -50°C. Excellent slag removal, also in narrow V-joints. For structural steels, fine-grained steels and low-temperature steels. Specially designed for windmill tower fabrication. Ideal for single and multi wire procedures. Suitable for both DC and AC welding and for the single- layer and multi-layer welding of unlimited plate thickness.

Density

1.1 kg/dm³

Basicity index

1.9

Flux consumption kg flux/kg wire

Voltage	DC+	AC
26	0.7	0.6
30	1.0	0.9
34	1.3	1.2
38	1.5	1.4

Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.24	12.24	0.05	0.2	1.6		0.5

Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 12.24	500	590	-30 -40 -46	60 40 35

Approvals

Wire	ABS	LR	DNV	BV	GL	RS	Ü	DB	VdTÜV
OK Autrod 12.24								x	x

Other approvals may be applicable. Please contact ESAB.

Classifications

Wire	EN 756	SFA/AWS A5.23
OK Autrod 12.24	S 46 3 AB S2Mo	F8A5-EA2-A3/F8P5-EA2-A3