

OK Flux 10.81LHS

Agglomerated aluminate-basic flux for Submerged Arc Welding. General purpose flux specially designed for fillet welding applications at high speeds primarily with single & twin wire systems for all carbon steels operated in DC. Further attributes include very good surface finish, slag detachability, concave horizontal fillets & uniform toe wetting. Major applications include pre-engineered buildings (PEB's), general construction etc.

Specifications

Classifications	EN ISO 14174 : S A AB 1 77 DC
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Slag Type	Aluminate-basic
Alloy Transfer	Silicon and Manganese alloying
Density	nom: 1.3 kg/dm ³

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
OK Autrod 12.22L	A5.17:EM12K/ 14171-B:SU21	A5.17: F7A2-EM12K

Approvals

Combined with Wire

*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.

Typical Weld Metal Analysis %

C	Mn	Si
OK Autrod 12.22L DC+ 550A, 29V		
0.06	1.90	0.70

Typical Wire Composition %

C	Mn	Si	S	P
OK Autrod 12.22L				
0.10	1.00	0.20	0.010	0.015

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.22L	As Welded DC+	460 MPa	540 MPa	30 %	80 J @ -18 °C 50 J @ -29 °C