

OK Flux 10.81LS

OK FLUX 10.81LS is an agglomerated Si and Mn alloying flux for submerged arc welding. Most suitable for applications where the dilution of base metal is high, e. g. in fillet welding and butt welding of thin and medium thick plates with a limited number of passes. The superior welding properties associated with the acid slag system of OK FLUX 10.81LS permit high travel speeds in butt and fillet welding. It offers superior bead shape, slag removal and surface finish. It can be easily used over rust and primer without running into the risk of porosity.

Specifications

Classifications	EN ISO 14174 : S A AB 1 65 AC
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Slag Type	Aluminate-rutile
Alloy Transfer	Silicon and Manganese alloying
Basicity Index	nom: 0.7
Grain Size	0.2-1.6 mm

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded	AWS - PWHT
OK Autrod 12.08L	A5.17: EL8/EL12 / 14171-A: S1	A5.17: F7AZ-EL8/EL12	A5.17: F7PZ-EL8/EL12
OK Autrod 12.22L	A5.17: EM12K / 14171-B: SU21	A5.17: F7AZ-EM12K	A5.17: F7PZ-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 12.08L DC+, 550A, 29V		
0.07	1.10	0.70
OK Autrod 12.22L DC+, 550A, 29V		
0.09	1.45	0.85

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.08L	As Welded AWS DC+	530 MPa	580 MPa	26 %	-
OK Autrod 12.08L	Stress Relieved AWS DC+	470 MPa	550 MPa	28 %	-
OK Autrod 12.22L	Stress Relieved AWS DC+	510 MPa	580 MPa	25 %	-
OK Autrod 12.22L	As Welded AWS DC+	550 MPa	620 MPa	24 %	-