

OK Flux 10.81L

OK FLUX 10.81L is an agglomerated Si and Mn alloying flux for submerged arc welding. It provides exceptional welding characteristics with a slag system that allows higher welding speeds. OK FLUX 10.81L gives good surface finish and excellent slag detachability. Due to high Mn & Si alloying, this is intended for limited number of passes and plate thickness up to about 20 mm.

Classifications	EN ISO 14174 : S A AR 1 87 DC
Slag Type	Aluminate-rutile
Alloy Transfer	Silicon and Manganese alloying
Basicity Index	nom 0.8
Grain Size	0.2-1.6 mm

Classifications

Wire	SFA/AWS - EN ISO	EN - As Welded	AWS - As Welded	AWS - PWHT
OK Autrod 12.08L	A5.17: EL8/EL12 / 14171-A: S1	14171-A: S 42 Z AR 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	BV	LR
OK Autrod 12.08L	•	•
OK Autrod 12.08L 1	•	-
OK Autrod 12.08L 2	-	•
OK Autrod 12.08L 3	-	•

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
OK Autrod 12.08L	As Welded AWS DC+	500 MPa	590 MPa	25 %	@
OK Autrod 12.08L	Stress Relieved AWS DC+	450 MPa	540 MPa	26 %	@
OK Autrod 12.22L	As Welded AWS DC+	540 MPa	600 MPa	25 %	@
OK Autrod 12.22L	Stress Relieved AWS DC+	500 MPa	560 MPa	26 %	@

Typical Weld Metal Analysis %

C	Mn	Si
OK Autrod 12.08L DC+, 550A, 29V		
0.06	1.15	0.70
OK Autrod 12.22L DC+, 550A, 29V		
0.08	1.40	0.80