OK Flux 10.71

OK Flux 10.71 is an agglomerated, basic flux for submerged arc welding. It is used for single and multi-run welding of all plate thicknesses. It can be combined with a wide range of solid wires and cored wires and thus it is suitable for all kinds of steels. OK Flux 10.71 combines good toughness values with excellent weldability. It is used for single and multiwire procedures such as tandem, twin-arc, tandem-twin welding and many more, for butt, overlap and fillet welds. It works equally well on DC and AC current. The good slag detachability and limited alloying of Si and Mn makes it well suited for multi-pass thick section welding. High welding speeds can be achieved producing a finely rippled weld metal, all this in combination with very good impact values. In general construction, OK Flux 10.71 is one of the most used SAW fluxes. Not just for structural steels and fine-grained steels, but also for weather resistant steels e.g. for bridges. Pressure vessels are welded with this flux, because it can be used for a wide range of steels including low temperature steels. This reduces the number of different fluxes a customer needs to have in stock. Wind tower production with plate thicknesses of greater than 50 mm require not only excellent slag detachability, particularly in the first run, and high deposition rates in all following runs, but also excellent toughness values. Since OK Flux 10.71 offers all this it is well established in this market segment. Other applications are in shipbuilding with approvals or in the production of pipes with steels up to X70 strength level. OK Flux 10.71 can also be combined with a number of SAW cored wires in order to increase the productivity and the mechanical properties of the weld metal.

Classifications:	EN ISO 14174:S A AB 1 67 AC H5
Approvals:	CE EN 13479, NAKS/HAKC RD 03-613-03, NAKS/HAKC RD 03-613-03, DB 51.039.05

Approvals are based on factory location. Please contact ESAB for more information.

Diffusible Hydrogen:	max 5 ml H/100g weld metal (Redried flux)
Slag Type:	Aluminate-basic
Alloy Transfer:	Slightly Silicon and moderately Manganese alloying
Density:	nom: 1.2 kg/dm3
Basicity Index:	nom: 1.5
Grain Size (met):	0.2-1.6 mm (10x65 mesh) or 0.315 -2.0 mm (9x48 mesh)

Flux Consumption		
Volts	**kg Flux / kg Wire DC+**	**kg Flux / kg Wire AC**
26 V	0.7 kg	0.6 kg
30 V	1.0 kg	0.9 kg
34 V	1.3 kg	1.2 kg
38 V	1.6 kg	1.4 kg

Dimensions	**Amps**	**Travel Speed**
Ø 4.0 mm	580 A	55 cm/min

Classifications	Wire	Weld Metal		
Wire	**AWS/EN**	**EN - As Welded**	**AWS - As Welded**	**AWS - PWHT**
OK Autrod 12.10	A5.17:EL12/ 14171-A:S1	S 35 4 AB S1	A5.17: F6A4-EL12	A5.17: F6P5-EL12
OK Autrod 12.20	A5.17:EM12/ 14171-A:S2	S 38 4 AB S2	A5.17: F7A4-EM12	A5.17: F6P4-EM12
OK Autrod 12.22	A5.17:EM12K/ 14171-A:S2Si	S 38 4 AB S2Si	A5.17: F7A5-EM12K	A5.17: F6P5-EM12K