



Product Data Sheet

S 'Submerged arc welding'

OK Flux 10.90

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REASON FOR ISSUE

EN 760 replaced by EN ISO 14174. Approval statement added.

GENERAL

Agglomerated aluminate-fluoride-basic flux for welding of 9 % Ni steels and other high alloyed steels with Ni based wires. The flux is manganese adding, which reduces the risk of hot cracking. Good slag detachability and nice bead appearance.

CLASSIFICATIONS Flux

EN ISO 14174

S A AF 2 55 53 MnNi DC

APPROVAL COMMENT

All others: See Flux-Wire combinations

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃-SiO₂

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃ +MnO	40	
CaF ₂	45	
SiO ₂ +TiO ₂	10	

Other properties:

Alloy Transfer

Chromium compensating. Nickel- and manganese alloying.

Basicity (Boniszewski)

nom: 1.7

FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
26	0.5	
30	0.6	
34	0.8	
38	1.0	
Current (A):	580	
Travel Speed (m/h):	33	
Dimension (mm):	4.0	

OTHER DATA

The flux is delivered in plastic-lined paperbags containing 25 kg.