

# OK Flux 10.71

SAW

Type Basic EN 760: SA AB 1 67 AC H5

## Description

OK Flux 10.71 is a basic, agglomerated, slightly Si- and Mn-alloying flux for submerged arc welding, specially designed for fillet welding and for the single- and multi-pass butt welding of mild, medium and high tensile steels. OK Flux 10.71 is of the aluminate-basic type and, for this slag system, it has a very high current-carrying capacity on both AC and DC and very good operating characteristics. OK Flux 10.71 is very suitable for narrow gap welding due to the excellent slag detachability and smooth side-wall blending.

## Density

approx. 1.2 kg/dm<sup>3</sup>

## Basicity index

1.6

## Flux consumption kg flux/kg wire

Voltage	DC+	AC
26	0.6	0.5
30	0.85	0.7
34	1.15	0.95
38	1.35	1.15

## Typical all weld metal composition, %

Wire	C	Si	Mn	Cr	Ni	Mo
OK Autrod 12.24	0.05	0.4	1.35			0.5
OK Autrod 12.34	0.09	0.4	1.5			0.5
OK Autrod 13.24	0.07	0.5	1.5		0.9	0.2
OK Autrod 13.27	0.05	0.4	1.4		2.2	-
						Cu:
OK Autrod 13.36	0.08	0.5	1.3	0.3	0.7	0,5

## Typical mech. properties all weld metal

Wire	Yield stress MPa	Tensile strength MPa	Charpy V °C	J
OK Autrod 12.24	500	580	+20	125
			0	100
			-20	60
			-40	30
OK Autrod 12.34	535	620	+20	120
			0	105
			-20	70
			-30	60
OK Autrod 13.24	560	630	+20	120
			-20	85
			-30	70
			-40	60
OK Autrod 13.27	500	600	-46	40
			-20	100
			-40	60
			-51	50
OK Autrod 13.36	490	580	+20	120
			-20	70
			-29	55

## Approvals

Wire	ABS	LR	DNV	BV	GL	RS	Ü	DB	VdTÜV
OK Autrod 12.24	3TM	3T, 3YM,	IIITYM	A3,	3YTM			x	x
	3YTM	3YT		A3YTM					
OK Autrod 12.34									
OK Autrod 13.24									
OK Autrod 13.27									x
OK Autrod 13.36									

## Classifications

Wire	EN 756	SFA/AWS A5.23
OK Autrod 12.24	S 46 2 AB S2Mo	F8A2-EA2-A4/F7P0-EA2-A4
OK Autrod 12.34	S 50 3 AB S3Mo	F8A4-EA4-A3/F8P2-EA4-A3
OK Autrod 13.24	S 50 4 AB S0	F8A5-EG-G/F8P4-EG-G
OK Autrod 13.27	S 46 5 AB S2Ni2	F8A6-ENi2-Ni2/F7P6-ENi2-Ni2
OK Autrod 13.36	S 46 3 AB S2Ni1Cu	F8A2-EG-G