

OK Flux 10.69

An agglomerated, basic flux specifically designed as a backing flux for one-sided submerged arc welding. The flux creates a perfect root weld with a smooth surface and has a good capability to support the molten weld pool, even at high heat inputs. Since this flux is a backing flux it does not take part in the welding process in a metallurgical way, so no alloying takes place from this flux. OK Flux 10.69 is mainly used in shipbuilding industries where it is applied to a copper backing bar with a groove that supports the flux on the backside of the weld joint. Welding is done with single wire, tandem or 3-wire systems. Plates up to approx 25 mm thickness can be welded in one run from a single side.

Classifications:	EN ISO 14174:S A CS 4
Slag Type:	Calcium-silicate
Alloy Transfer:	No alloying
Density:	nom: 1.3 kg/dm ³
Basicity Index:	nom: 1.8
Grain Size (met):	0.2-1.25 mm (14x65 mesh)