



## OK FLUX 10.71L

An agglomerated slightly Si and Mn alloying basic flux for SAW

Classification AWS A5.17: F6A2-EL8/EL12  
F7A4/F6P5-EM12K  
F7A4/F7P6-EH10K  
F7A4/F7P5-EH14  
AWS A5.23: F8A2/F7P0-EA2-A4  
F9A0/F8P0-EA3K-A3

**BASICITY INDEX:** 1.5

### TYPICAL WELD METAL PROPERTIES

OK FLUX 10.71L/	C	Si	Mn	Mo	YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	Elongation (%)	CVN Impact (Joules)	Impact Temperature (°C)
OK AUTROD 12.08L	0.06	0.20	0.90	-	390	450	25	70	-30
OK AUTROD 12.22L	0.08	0.40	1.35	-	450	540	30	35	-40
ESAB SA10K	0.07	0.50	1.65	-	490	580	26	30	-40
OK AUTROD 12.40L	0.07	0.40	1.80	-	500	590	27	40	-40
OK AUTROD 12.24L	0.08	0.40	1.25	0.50	550	610	24	50	-30
OK AUTROD 12.33L	0.07	0.75	2.00	0.40	630	700	25	35	-18

**PACKING:** OK FLUX 10.71L is packed in plastic lined paper bags containing 25 Kg.

## OK FLUX 10.81L

An agglomerated Si and Mn alloying acidic flux for SAW

Classification AWS A5.17: F7AZ/F7PZ-EL8/EL12

**BASICITY INDEX:** 0.7

### TYPICAL WELD METAL PROPERTIES

OK FLUX 10.81L/	C	Si	Mn	YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	Elongation (%)
OK AUTROD 12.08L	0.06	0.70	1.20	540	590	25

**PACKING:** OK FLUX 10.81L is packed in plastic lined paper bag containing 25 Kg.

### DESCRIPTION

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

### DESCRIPTION

OK FLUX 10.81L is an acidic agglomerated Si and Mn alloying flux for submerged arc welding. It provides exceptional welding characteristics with a slag system that allows higher welding speeds. It is specially designed for use in combination with OK AUTROD 12.08L.