



OK FLUX 10.92, 10.93, 10.94

Fluxes for Stainless Steels

Description

OK Flux 10.92 is a Cr alloying bonded flux for welding stainless steels. The Cr alloying compensates for Cr losses in the arc during welding. It is recommended for welding austenitic grades such as 304, and 316. Basicity Index: 1.0

OK Flux 10.93 is a basic non-alloying bonded flux for welding stainless steels. It is recommended for welding austenitic grades, as well as high-alloyed CrNi, CrNiMo, and Duplex stainless steels. Basicity Index: 1.7

OK Flux 10.94 is a basic Cr alloying bonded flux for welding stainless steels. It is recommended for welding high-alloyed CrNiMo steels such as super-duplex stainless steels. Basicity Index: 1.7

These fluxes can be used with wires up to 5/32 in (4.0 mm) diameter and currents up to 800 A.

Typical Welding Parameters

Weld Type	Plate Thickness in. (mm)	Electrode Diameter in. (mm)	Amps	Volts	Travel Speed ipm (cm/min)	Comments
Square Groove Butt	3/8 (10)	5/32 (4.0)	1 st side: 625 2 nd side: 700	29	25 (65)	One pass each side
Horizontal Fillet	5/16 (8)	1/8 (3.2)	500	31	24 (60)	5/32" (4 mm) leg

Typical Mechanical Properties

Flux	Wire	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	CVN ft-lbs (J)	Temp. @°F (°C)
OK Flux 10.92	ER308L	84 (580)	53 (365)	44 (60)	-76 (-60)
				37 (50)	-320 (-196)
OK Flux 10.92	ER309L	83 (575)	59 (410)	37 (50)	-4 (-20)
OK Flux 10.92	ER316L	86 (590)	56 (385)	41 (55)	-95 (-70)
OK Flux 10.93	ER308L	81 (560)	58 (400)	48 (65)	-76 (-60)
				30 (40)	-320 (-196)
OK Flux 10.93	ER309L	83 (570)	62 (430)	52 (70)	-76 (-60)
				26 (35)	-320 (-196)
OK Flux 10.93	ER316L	82 (565)	57 (390)	66 (90)	-76 (-60)
				29 (40)	-320 (-196)
OK Flux 10.94	ER347	90 (620)	66 (455)	52 (70)	-76 (-60)
				22 (30)	-320 (-196)
OK Flux 10.94	Super Duplex 25%Cr 10%Ni 4%Mo	120 (830)	91 (625)	37 (50)	-76 (-60)

Typical Undiluted Weld Metal Analysis (%)

Flux	Wire	C	Mn	Si	Cr	Ni	Mo
OK Flux 10.92	ER308L	0.03	1.0	0.9	20	10	--
OK Flux 10.92	ER309L	0.02	1.1	0.8	24	13	--
OK Flux 10.92	ER316L	0.02	1.0	0.8	19	12	2.7
OK Flux 10.93	ER308L	0.02	1.8	0.7	20	10	--
OK Flux 10.93	ER309L	0.03	1.5	0.6	24	12.5	--
OK Flux 10.93	ER316L	0.03	1.4	0.6	18.5	11.5	2.7
OK Flux 10.94	ER347	0.04	1.0	0.4	19.6	9.6	--
OK Flux 10.94	Super Duplex 25%Cr 10%Ni 4%Mo	0.4	0.5	0.5	25	9.5	4.0

Standard Part Numbers and Packages

Product	Part Number	Package Weight Kg (Lb.)	Pallet Weight Kg (Lb.)
OK Flux 10.92	1092000000	25 (55)	1000 (2200)
OK Flux 10.93	1093000000	20 (44)	500 (1100)
OK Flux 10.94	1094000000	25 (55)	1000 (2200)

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