OK Flux 10.79

Agglomerated, aluminate-basic flux for Submerged Arc Welding with high tolerance to rust & mill scale. Smooth surface finish and nice-looking welds also under severe plate surface conditions. Easy slag detachability. Primarily for horizontal fillet welds, also for butt welds. High welding speeds. For general construction, beam fabrication, pressure vessels, transport industries, etc. Suitable for DC and AC welding. Intended for a limited number of passes and plate thickness up to about 25 mm.

Specifications	
Classifications	EN ISO 14174 : S A AB 1 77 AC
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Slag Type	Aluminate-basic
Alloy Transfer	Moderately Silicon and Manganese alloying
Density	nom: 1.3 kg/dm3
Basicity Index	nom: 1.0

Classifications_SAW	Wire	Weld Metal	
Wire	**AWS/EN**	**AWS - As Welded**	**AWS - PWHT**
OK Autrod 12.22	A5.17:EM12K 14171-A:S2Si	A5.17: F7A2-EM12K	A5.17: F6P2-EM12K

Approvals_SAW		
Wire	**CE**	**UKCA**
OK Autrod 12.22	•	•

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
OK Autrod 12.22 AC , 580A, 29V		
0.06	1.6	0.5
OK Autrod 12.22 DC+, 580A, 29V		
0.05	1.7	0.6

SAW_Typical_Mech_Properties					
Wire	**Testing Condition**	**Yield Strength**	**Tensile Strength**	**Elongation**	**Charpy V-Notch Result**
OK Autrod 12.22	As Welded AWS DC+	440 MPa	520 MPa	30 %	80 J @ -18 °C 50 J @ -29 °C
OK Autrod 12.22	Stress Relieved AWS DC+ (1 hour(s))	390 MPa	490 MPa	33 %	100 J @ -18 °C 60 J @ -29 °C