OK Flux 10.62

OK Flux 10.62 är ett högbasiskt, mineralhaltigt, agglomererat icke legerande svetspulver för pulverbågsvetsning. Svetsgodset kan kontrolleras fullständigt genom rätt val av tråd oberoende av svetsparametrar och är därför mycket användbar vid flersträngsförfarande i grova material vid entråds- eller flertrådsförfarande. OK Flux 10.62 är utvecklat för flersträngsförfarande i olegerade, ordinära och höghållfasta stål, samt låglegerade stål med slagseghetskrav ned till -40 °C/-60 °C, även CTOD-testad. Eftersom OK Flux 10.62 är av högbasisk typ är det mycket strömtåligt både på lik- och växelström. OK Flux 10.62 fungerar bäst i det lägre spänningsområdet. För att öka produktiviteten utan att förlora mekaniska egenskaper användes OK Flux 10.62 tillsammans med järnpulvertillsats. Pulvret är väl anpassat för narrowgapsvetsning (s.k. smalfog) på grund av dess goda slagglossning och medverkan till en mycket jämn stränganslutning mot fogytan. Tryckkärl i nukleära anläggningar och offshorekonstruktioner där bra CTOD resultat krävs är två områden, där OK Flux 10.62 med fördel kan användas. OK Flux10.62 avsätter ett lågkvävehaltigt (ca 300 ppm) och ett låghydrogenhaltigt (<5ml/100g) svetsgods. (Art nr 1062)

Tekniska data	
Klassificeringar	EN ISO 14174 : S A FB 1 55 AC H5 EN ISO 14174 : S A FB 1 55 AC H4 only BlockPac/moisture-protection
Godkännanden	CE : EN 13479 DB : 51.039.07 NAKS/HAKC : RD 03-613-03 NAKS/HAKC : RD 03-613-03

Diffunderbart väte	max 5 ml H/100g weld metal (Redried flux); max 4 ml H/100g in BlockPac (moisture protection)
Slaggtyp	Fluoride-basic
Legeringsöverföring	No Silicon or Manganese alloying
Densitet	nom: 1.1 kg/dm3
Basisitets index	nom: 3.2

Fluxförbrukning		
Bågspänning	**Flux/trådförbrukning, kg DC**	**Flux/trådförbrukning, kg AC**
34 V	1.3 kg	1.2 kg
30 V	1.0 kg	0.9 kg
26 V	0.7 kg	0.6 kg
38 V	1.6 kg	1.4 kg

Mått	**Svetsström**	**Framföringshastighet**
Ø 4.0 mm	580 A	55 m/min

Klassificering				
Tråd	**AWS/EN**	**EN**	**AWS**	**AWS - Värmebehandlat**
ESAB SA10K	A5.17:EH10K/ 14171-B: SU10		A5.17: F7A6-EH10K	A5.17: F7P8-EH10K
OK Autrod 12.22	A5.17:EM12K/ 14171-A: S2Si	14171-A: S 38 5 FB S2Si	A5.17: F7A8-EM12K	A5.17: F6P8-EM12K
OK Autrod 12.24	A5.23:EA2/ 14171-A:S2Mo; 24598-A:S S Mo	14171-A: S 46 4 FB S2Mo	A5.23: F8A6-EA2-A2	A5.23: F8P6-EA2-A2
OK Autrod 12.24L	A5.23:EA2/ 14171-B: SU2M3		A5.23: F8A4-EA2-A2	A5.23: F8P4-EA2-A2
OK Autrod 12.32	A5.17:EH12K/ 14171-A: S3Si	14171-A: S 46 6 FB S3Si	A5.17: F7A8-EH12K	A5.17: F7P8-EH12K
OK Autrod 12.33L	A5.23:EA3K		A5.23: F10A4-EA3K-G	A5.23: F9P4-EA3K-G
OK Autrod 12.34	A5.23:EA4/ 14171-A:S3Mo; 24598-A:S S MnMo	14171-A: S 50 4 FB S3Mo	A5.23: F8A6-EA4-A4	A5.23: F8P6-EA4-A4
OK Autrod 12.40	A5.17:EH14/ 14171-A:S4	14171-A: S 50 4 FB S4	A5.17: F7A6-EH14	A5.17: F7P6-EH14
OK Autrod 12.40L	A5.17:EH14/ 14171-B:SU41		A5.17: F7A6-EH14	A5.17: F7P6-EH14
OK Autrod 13.10 SC	A5.23:EB2R/ 24598-A:S S CrMo1			A5.23: F8P2-EB2R-B2

OK Flux 10.62

Klassificering				
Tråd	**AWS/EN**	**EN**	**AWS**	**AWS - Värmebehandlat**
OK Autrod 13.20 SC	A5.23:EB3R/ 24598-A:S S CrMo2			A5.23: F8P2-EB3R-B3
OK Autrod 13.21	A5.23:ENi1/ 14171-A:S2Ni1	14171-A: S 42 4 FB S2Ni1	A5.23: F7A6-ENi1-Ni1	A5.23: F7P8-ENi1-Ni1
OK Autrod 13.24	A5.23:ENi6/ 14171-A: S3Ni1Mo0,2	14171-A: S 50 6 FB S3Ni1Mo0.2	A5.23: F8A10-ENi6-Ni6	A5.23: F8P8-ENi6-Ni6
OK Autrod 13.27	A5.23:ENi2/ 14171-A:S2Ni2	14171-A: S 46 7 FB S2Ni2	A5.23: F7A10-ENi2-Ni2	A5.23: F7P10-ENi2-Ni2
OK Autrod 13.36	A5.23:EG/ 14171-A: S2Ni1Cu	14171-A: S 46 5 FB S2Ni1Cu	A5.23: F8A6-EG-G	
OK Autrod 13.40	A5.23:EG/ 14171-A: S3Ni1Mo; 26304-A: S3Ni1Mo; 26304-B: (SUN2M2)	26304-A: S 62 6 FB S3Ni1Mo (AC)	A5.23: F10A8-EG-F3 (AC)	A5.23: F9P8-EG-F3
OK Autrod 13.43	A5.23:EG/ 26304-A:S3Ni2, 5CrMo; 26304-B: (SUN4C1M3)	26304-A: S 69 6 FB S3Ni2, 5CrMo	A5.23: F11A8-EG-G	A5.23: F11P8-EG-G
OK Autrod 13.49	A5.23:ENi3/ 14171-A:S2Ni3	14171-A: S 46 8 FB S2Ni3	A5.23: F8A15-ENi3-Ni3	A5.23: F8P15-ENi3-Ni3
Spoolarc 95	A5.23:EM2			

Godkännanden											
Tråd	**ABS**	**BV**	**CE**	**DB**	**DNV**	**GL**	**LR**	**VdTÜV**	**RINA**	**RS**	**DNV-GL**
OK Autrod 12.22	•	•	•	•	•	•	•	•	-	-	-
OK Autrod 12.24	-	-	•	-	-	-	-	•	-	-	-
OK Autrod 12.32	•	•	•	•	•	•	•	•	•	•	-
OK Autrod 12.34	•	•	•	-	-	-	•	-	-	•	•
OK Autrod 12.40	-	-	-	-	-	-	-	-	-	-	•
OK Autrod 13.10 SC	-	-	•	•	-	-	-	•	-	-	-
OK Autrod 13.20 SC	-	-	•	-	-	-	-	•	-	-	-
OK Autrod 13.24	•	•	•	-	•	•	•	-	-	-	-
OK Autrod 13.27	•	•	•	•	•	•	•	•	•	•	-
OK Autrod 13.36	-	-	•	-	-	-	-	-	-	-	-
OK Autrod 13.40	•	•	•	-	•	•	•	•	-	-	-
OK Autrod 13.43	•	•	•	-	•	•	•	-	-	-	-
OK Tubrod 15.27S	•	-	•	-	•	•	•	-	-	-	-

Trådens sammansättning %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**Ti**
Spoolarc U515									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
ESAB SA10K									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 12.22									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 12.24									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 12.24L									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 12.32									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07

OK Flux 10.62

Trådens sammansättning %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**Ti**
OK Autrod 12.33L									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 12.34									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 12.40									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 12.40L									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.10 SC									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.20 SC									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.21									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.24									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.27									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.36									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.40									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.43									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
OK Autrod 13.49									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
Spoolarc 120									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
Spoolarc 44									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
Spoolarc 53									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
Spoolarc 71									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
Spoolarc 86									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
Spoolarc 95									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07
Spoolarc ENi4									
0.09	1.01	0.19	0.015	0.020	2.19	1.21	0.50	0.10	0.07

Trådens sammansättning %
X-bar
Spoolarc U515
11
ESAB SA10K
11

OK Flux 10.62

Trådens sammansättning %
X-bar
OK Autrod 12.22
11
OK Autrod 12.24
11
OK Autrod 12.24L
11
OK Autrod 12.32
11
OK Autrod 12.33L
11
OK Autrod 12.34
11
OK Autrod 12.40
11
OK Autrod 12.40L
11
OK Autrod 13.10 SC
11
OK Autrod 13.20 SC
11
OK Autrod 13.21
11
OK Autrod 13.24
11
OK Autrod 13.27
11
OK Autrod 13.36
11
OK Autrod 13.40
11
OK Autrod 13.43
11
OK Autrod 13.49
11
Spoolarc 120
11
Spoolarc 44
11
Spoolarc 53
11
Spoolarc 71
11
Spoolarc 86
11
Spoolarc 95
11
Spoolarc ENi4

OK Flux 10.62

Trådens sammansättning %
X-bar
11

Svetsgodsanalys %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
Spoolarc U515 Stress Relieved 1 hr. @ 1275°F									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
ESAB SA10K DC+ 550A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.22 AC, 580 A, 29 V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.22 DC+, 580 A, 29 V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.24 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.24L									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.24L DC+ 550A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.32 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.32 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.33L									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.34 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.34 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.40 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.40 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 12.40L DC+ 550A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.10 SC AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.10 SC DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.20 SC AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.20 SC DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.21 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.21 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.24 DC+, 580A, 29V									

OK Flux 10.62

Svetsgodsanalys %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Al**
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.24 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.27 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.27 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.36 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.36 DC+, 525A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.40 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.40 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.43 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.43 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.49 DC+, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
OK Autrod 13.49 AC, 580A, 29V									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 120									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 44 As Welded									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 44 Stress Relieved 1 hr. @ 1150°F									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 53 Stress Relieved 1 hr. @ 1150°F									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 53 As Welded									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 71 As Welded									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 71 Stress Relieved 1 hr. @ 1150°F									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 86 Stress Relieved 1 hr. @ 1150°F									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc 95 As Welded									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc ENi4 As Welded									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020
Spoolarc ENi4 Stress Relieved 1 hr. @ 1150°F									
0.07	1.0	0.30	0.015	0.025	2.1	0.028	0.45	0.005	0.020

OK Flux 10.62

Svetsgodsanalys %			
Cu	**Nb**	**Ti**	**Co**
Spoolarc U515 Stress Relieved 1 hr. @ 1275°F			
0.083	0.002	0.019	0.004
ESAB SA10K DC+ 550A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.22 AC, 580 A, 29 V			
0.083	0.002	0.019	0.004
OK Autrod 12.22 DC+, 580 A, 29 V			
0.083	0.002	0.019	0.004
OK Autrod 12.24 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.24L			
0.083	0.002	0.019	0.004
OK Autrod 12.24L DC+ 550A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.32 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.32 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.33L			
0.083	0.002	0.019	0.004
OK Autrod 12.34 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.34 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.40 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.40 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 12.40L DC+ 550A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.10 SC AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.10 SC DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.20 SC AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.20 SC DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.21 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.21 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.24 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.24 AC, 580A, 29V			
0.083	0.002	0.019	0.004

OK Flux 10.62

Svetsgodsanalys %			
Cu	**Nb**	**Ti**	**Co**
OK Autrod 13.27 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.27 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.36 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.36 DC+, 525A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.40 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.40 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.43 AC, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.43 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.49 DC+, 580A, 29V			
0.083	0.002	0.019	0.004
OK Autrod 13.49 AC, 580A, 29V			
0.083	0.002	0.019	0.004
Spoolarc 120			
0.083	0.002	0.019	0.004
Spoolarc 44 As Welded			
0.083	0.002	0.019	0.004
Spoolarc 44 Stress Relieved 1 hr. @ 1150°F			
0.083	0.002	0.019	0.004
Spoolarc 53 Stress Relieved 1 hr. @ 1150°F			
0.083	0.002	0.019	0.004
Spoolarc 53 As Welded			
0.083	0.002	0.019	0.004
Spoolarc 71 As Welded			
0.083	0.002	0.019	0.004
Spoolarc 71 Stress Relieved 1 hr. @ 1150°F			
0.083	0.002	0.019	0.004
Spoolarc 86 Stress Relieved 1 hr. @ 1150°F			
0.083	0.002	0.019	0.004
Spoolarc 95 As Welded			
0.083	0.002	0.019	0.004
Spoolarc ENi4 As Welded			
0.083	0.002	0.019	0.004
Spoolarc ENi4 Stress Relieved 1 hr. @ 1150°F			
0.083	0.002	0.019	0.004

Mekaniska egenskaper					
Tråd	**Villkor**	**Sträckgräns**	**Brottgräns**	**Förlängning**	**Charpy V-Notch**
ESAB SA10K	Helsvetsgods DC+	490 MPa	570 MPa	28 %	100 J @ -29 °C 55 J @ -40 °C

OK Flux 10.62

Mekaniska egenskaper					
Tråd	**Villkor**	**Sträckgräns**	**Brottgräns**	**Förlängning**	**Charpy V-Notch**
					40 J @ -51 °C
ESAB SA10K	PWHT DC+ (15 hour (s))	410 MPa	510 MPa	37 %	210 J @ -40 °C 180 J @ -51 °C 105 J @ -62 °C
ESAB SA10K	PWHT DC+ (10 hour (s))	410 MPa	510 MPa	36 %	230 J @ -40 °C 170 J @ -51 °C 100 J @ -62 °C
ESAB SA10K	PWHT DC+ (22 hour (s))	410 MPa	500 MPa	36 %	205 J @ -51 °C 150 J @ -62 °C
ESAB SA10K	PWHT DC+ (19 hour (s))	410 MPa	500 MPa	38 %	200 J @ -51 °C 150 J @ -62 °C
ESAB SA10K	PWHT DC+ (1 hour(s))	450 MPa	540 MPa	30 %	110 J @ -29 °C 80 J @ -40 °C 35 J @ -51 °C 30 J @ -62 °C
ESAB SA10K	PWHT DC+ (5 hour(s))	410 MPa	520 MPa	35 %	200 J @ -40 °C 140 J @ -51 °C 40 J @ -62 °C
OK Autrod 12.22	Helsvetsgods AWS DC+	410 MPa	500 MPa	33 %	170 J @ 0 °C 160 J @ -20 °C 90 J @ -40 °C 70 J @ -50 °C 35 J @ -62 °C
OK Autrod 12.22	Helsvetsgods EN AC	440 MPa	510 MPa	29 %	180 J @ 0 °C 170 J @ -20 °C 90 J @ -40 °C 80 J @ -50 °C
OK Autrod 12.24	Helsvetsgods AWS DC+	500 MPa	580 MPa	25 %	140 J @ 20 °C 115 J @ 0 °C 80 J @ -20 °C 60 J @ -40 °C 45 J @ -51 °C
OK Autrod 12.24	Helsvetsgods EN AC	520 MPa	600 MPa	24 %	150 J @ 20 °C 125 J @ 0 °C 100 J @ -20 °C 55 J @ -40 °C 40 J @ -51 °C
OK Autrod 12.24L	PWHT DC+ (1 hour(s))	530 MPa	590 MPa	27 %	70 J @ -18 °C 35 J @ -29 °C 30 J @ -40 °C
OK Autrod 12.24L	Helsvetsgods DC+	550 MPa	620 MPa	25 %	90 J @ -18 °C 40 J @ -29 °C 30 J @ -40 °C
OK Autrod 12.32	Helsvetsgods EN AC	520 MPa	600 MPa	26 %	175 J @ 20 °C 170 J @ 0 °C 110 J @ -30 °C 90 J @ -40 °C 60 J @ -60 °C
OK Autrod 12.32	Helsvetsgods AWS DC+	475 MPa	560 MPa	28 %	175 J @ 20 °C 150 J @ 0 °C 130 J @ -30 °C 110 J @ -40 °C 70 J @ -62 °C

OK Flux 10.62

Mekaniska egenskaper

Tråd	Villkor	Sträckgräns	Brottgräns	Förlängning	Charpy V-Notch
OK Autrod 12.33L	Helsvetsgods DC+	660 MPa	740 MPa	25 %	45 J @ -29 °C 30 J @ -40 °C
OK Autrod 12.33L	PWHT DC+ (1 hour(s))	620 MPa	690 MPa	26 %	50 J @ -29 °C 30 J @ -40 °C
OK Autrod 12.34	Helsvetsgods AWS DC+	540 MPa	620 MPa	24 %	170 J @ 20 °C 160 J @ 0 °C 140 J @ -20 °C 115 J @ -40 °C 45 J @ -51 °C
OK Autrod 12.34	Helsvetsgods EN AC	560 MPa	630 MPa	25 %	160 J @ 20 °C 150 J @ 0 °C 130 J @ -20 °C 100 J @ -40 °C 55 J @ -51 °C
OK Autrod 12.40	Helsvetsgods AWS DC+	530 MPa	620 MPa	26 %	140 J @ 20 °C 110 J @ 0 °C 80 J @ -20 °C 50 J @ -40 °C 40 J @ -51 °C
OK Autrod 12.40	Helsvetsgods EN AC	550 MPa	630 MPa	22 %	150 J @ 20 °C 105 J @ 0 °C 70 J @ -20 °C 55 J @ -40 °C 40 J @ -51 °C
OK Autrod 12.40L	Helsvetsgods DC+	520 MPa	610 MPa	26 %	100 J @ -29 °C 85 J @ -40 °C 40 J @ -51 °C
OK Autrod 12.40L	PWHT DC+ (1 hour(s))	450 MPa	550 MPa	28 %	110 J @ -29 °C 90 J @ -40 °C 50 J @ -51 °C
OK Autrod 13.21	Helsvetsgods AWS DC+	470 MPa	560 MPa	28 %	195 J @ 20 °C 185 J @ 0 °C 160 J @ -20 °C 70 J @ -40 °C 60 J @ -51 °C
OK Autrod 13.21	Helsvetsgods EN AC	520 MPa	595 MPa	24 %	170 J @ 20 °C 165 J @ 0 °C 150 J @ -20 °C 70 J @ -40 °C 50 J @ -51 °C
OK Autrod 13.24	Helsvetsgods AWS DC+	530 MPa	620 MPa	25 %	120 J @ -40 °C 110 J @ -50 °C 70 J @ -60 °C 50 J @ -73 °C
OK Autrod 13.24	Helsvetsgods EN AC	560 MPa	640 MPa	23 %	130 J @ -40 °C 120 J @ -50 °C 80 J @ -60 °C
OK Autrod 13.27	Helsvetsgods AWS DC+	460 MPa	570 MPa	28 %	140 J @ -20 °C 110 J @ -40 °C 80 J @ -60 °C 50 J @ -73 °C
OK Autrod 13.27	Helsvetsgods EN AC	520 MPa	605 MPa	27 %	150 J @ -20 °C 120 J @ -40 °C

OK Flux 10.62

Mekaniska egenskaper					
Tråd	**Villkor**	**Sträckgräns**	**Brottgräns**	**Förlängning**	**Charpy V-Notch**
					80 J @ -60 °C 60 J @ -70 °C
OK Autrod 13.36	Helsvetsgods EN AC	550 MPa	620 MPa	25 %	110 J @ -40 °C 90 J @ -50 °C
OK Autrod 13.36	Helsvetsgods AWS DC+	500 MPa	590 MPa	27 %	70 J @ -40 °C 60 J @ -51 °C
OK Autrod 13.40	Helsvetsgods EN AC	660 MPa	730 MPa	24 %	110 J @ -40 °C 90 J @ -50 °C 70 J @ -60 °C
OK Autrod 13.40	Helsvetsgods AWS DC+	610 MPa	690 MPa	24 %	90 J @ -40 °C 80 J @ -50 °C 50 J @ -62 °C
OK Autrod 13.40	Helsvetsgods AWS AC	650 MPa	730 MPa	23 %	100 J @ -40 °C 90 J @ -50 °C 60 J @ -62 °C
OK Autrod 13.40	Helsvetsgods EN DC+	620 MPa	700 MPa	23 %	100 J @ -40 °C 80 J @ -50 °C 60 J @ -60 °C 50 J @ -62 °C
OK Autrod 13.43	Helsvetsgods AWS DC+	700 MPa	800 MPa	21 %	100 J @ -20 °C 75 J @ -40 °C 65 J @ -50 °C 50 J @ -62 °C
OK Autrod 13.43	Helsvetsgods EN ISO-A AC	720 MPa	845 MPa	19 %	110 J @ -20 °C 90 J @ -40 °C 70 J @ -50 °C 60 J @ -60 °C
OK Autrod 13.49	Helsvetsgods EN AC	560 MPa	640 MPa	22 %	95 J @ -70 °C 75 J @ -80 °C 55 J @ -90 °C
OK Autrod 13.49	Helsvetsgods AWS DC+	500 MPa	600 MPa	27 %	95 J @ -70 °C 40 J @ -101 °C
Spoolarc 120	Helsvetsgods	758 MPa	827 MPa	21 %	90 J @ -51 °C
Spoolarc 44	Helsvetsgods	630 MPa	689 MPa	26 %	136 J @ -51 °C
Spoolarc 53	Helsvetsgods	465 MPa	553 MPa	32 %	178 J @ -62 °C
Spoolarc 71	Helsvetsgods	511 MPa	590 MPa	28 %	126 J @ -51 °C
Spoolarc 95	Helsvetsgods	686 MPa	758 MPa	25 %	101 J @ -51 °C
Spoolarc ENi4	Helsvetsgods	532 MPa	618 MPa	27 %	145 J @ -62 °C 109 J @ -73 °C