

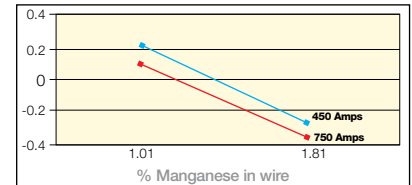


OK Flux 50 is a neutral, fused flux that performs well in a wide variety of applications. It is used for build up and hardsurfacing applications, and also for making butt and fillet welds in structural and pressure vessel steel plate. OK Flux 50 is suitable for use with AC or DC power in single or multiwire applications. It is available in two mesh sizes. The 8x48 size is recommended for build up and hardsurfacing applications at currents of up to 800 amps. The 12x150 size is suitable for use at up to 1100 amps and is recommended for all applications where the travel speed is less than 60 in./min (150 cm/min). OK Flux 50 is not recommended for use over rust or heavy mill scale.

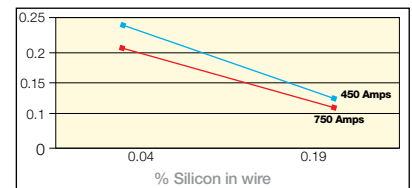
Flux Consumption
(lb. Flux / lb. Wire)

Voltage	DC+
26	1.09
30	1.53
34	2.05
38	2.49

% Mn pick-up from flux



% Si pick-up from flux



Code and Specification Data:

AWS A5.17 F7A2-EH14
AWS A5.17 F7A2-EM12K

Basicity Index: 0.70

Chemical Composition:

SiO ₂ + TiO ₂	40	CaO + MgO	5
Al ₂ + MnO	45	Fluorides	5

Typical Mechanical Properties

Wire	Weld Condition	Yield Strength		Tensile Strength		% Elong in 2"	CVN		Temp.		AWS Class
		ksi	(MPa)	ksi	(MPa)		(51 mm)	ft.-lbs.	(J)	@ °F	
Spoolarc 81	As Welded	60	415	74	510	25	28	38	-20	-29	F7A2-EM12K
Spoolarc 36	As Welded	62	425	74	510	24	26	35	-20	-29	F7A2-EH14

Typical Undiluted Weld Metal Analysis (%)

Wire	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
Spoolarc 81	0.05	1.12	0.45	0.023	0.009	-	-	-	-
Spoolarc 36	0.07	1.55	0.43	0.024	0.005	-	-	-	-