



# OK Flux 281

Bonded Flux

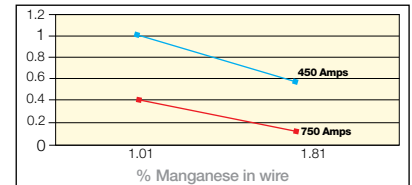


**OK Flux 281** is intended for welding gauge thickness and thin steel plate (up to 3/8 in. thick) for butt, lap and fillet welds. Due to the excellent operating characteristics, quality welds with self-peeling slag and free from undercut may be achieved with welding speeds ranging from 50 to 100 inches per minute.

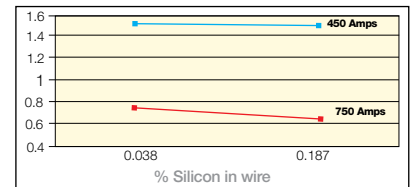
### Flux Consumption (lb. Flux / lb. Wire)

Voltage	DC+
26	0.62
30	0.76
34	.97
38	1.35

### % Mn pick-up from flux



### % Si pick-up from flux



### Code and Specification Data:

AWS A5.17 F7AO-EM13K  
AWS A5.17 F7AO-EM12K

**Basicity Index:** 0.5

### Chemical Composition:

SiO<sub>2</sub> + TiO<sub>2</sub> 25 Fluorides 5  
Al<sub>2</sub> + MnO 50

### Typical Mechanical Properties

Wire	Weld Condition	Yield Strength		Tensile Strength		% Elong in 2" (51 mm)	CVN		Temp.		AWS Class
		ksi	(MPa)	ksi	(MPa)		ft.-lbs.	(J)	@ °F	(°C)	
Spoolarc 81	As Welded	78	540	92	635	25	28	20	0	-18	F7A0-EM12K
Spoolarc 29S	As Welded	89	615	99	680	22	23	31	0	-18	F7A0-EM13K

### Typical Undiluted Weld Metal Analysis (%)

Wire	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
Spoolarc 81	0.07	1.80	0.90	0.025	0.013	-	-	-	-
Spoolarc 29S	0.07	1.80	1.00	0.023	0.014	-	-	-	-

**ESAB** has more submerged arc experience than any other leading welding provider.

