



OK Flux 350

Bonded Flux

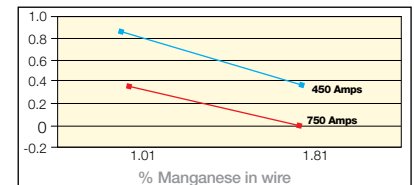


OK Flux 350 is an active bonded flux for making butt and fillet welds in carbon steel plate up to 1" (25 mm) thick. It produces a smooth weld surface with uniform edges. The slag is generally free peeling. Its performance is very good even when the plate surface is covered with rust and mill scale. OK Flux 350 is suitable for use with AC or DC power in single or multiwire applications. It is recommended for butt welding of thin wall pressure vessels, rail cars and structural steel plate. It is used for fillet welding in shipbuilding, pressure vessel and structural applications. OK Flux 350 also is widely used as a backing flux in one sided welding applications. It provides good performance at currents up to 1100 amps.

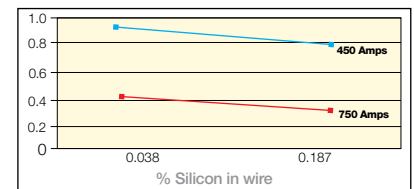
Flux Consumption (lb. Flux / lb. Wire)

Voltage	DC+
26	0.61
30	0.83
34	1.4
38	1.36

% Mn pick-up from flux



% Si pick-up from flux



Code and Specification Data:

AWS A5.17 / ASME SFA 5.17 F7A2-EM13K
 AWS A5.17 / ASME SFA 5.17 F7A2-EM12K
 AWS A5.17 / ASME SFA 5.17 F7A2-EL12

Basicity Index: 0.9

Chemical Composition:

SiO ₂ + TiO ₂	40	CaO + MgO	25
Al ₂ + MnO	20	Fluorides	5

Typical Mechanical Properties

Wire	Weld Condition	Yield Strength		Tensile Strength		% Elong in 2"	CVN		Temp.		AWS Class
		ksi	(MPa)	ksi	(MPa)		ft.-lbs.	(J)	@ °F	(°C)	
Spoolarc 80	As Welded	62	425	76	525	30	36	49	-20	-29	F7A2-EL12
Spoolarc 81	As Welded	66	455	80	550	26	31	42	-20	-29	F7A2-EM12K
Spoolarc 29S	As Welded	71	490	87	600	28	24	32	-20	-29	F7A2-EM13K

Typical Undiluted Weld Metal Analysis (%)

Wire	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
Spoolarc 80	0.05	1.40	0.50	0.022	0.015	-	-	-	-
Spoolarc 81	0.04	1.80	0.70	0.022	0.010	-	-	-	-
Spoolarc 29S	0.04	1.90	0.90	0.023	0.015	-	-	-	-

The broadest range of **Spoolarc** subarc wires and **OK flux** products to help you achieve the best results at the lowest possible cost.