

## OK Flux 231

OK Flux 231 is an active, bonded flux designed for fillet and butt welding of carbon steel plate. It provides excellent tolerance of rust and mill scale so joint preparation can be minimized. This flux will produce horizontal fillets up to 3/8" (9.5 mm) leg size without undercut or rollover. The slag peeling is excellent. OK Flux 231 can be used for multipass welding, but because Mn and Si buildup is possible, welding voltage should be kept to a minimum and plate thickness should be limited to 1" (25 mm). OK Flux 231 is suitable for DC single and parallel wire welding at currents up to 1000 A. It is used for welding rail cars, water heater tanks, ship plates, and structural steel.

<b>Classifications</b>	AWS A5.17 : F7A2-EL12 AWS A5.17 : F7A2-EM12K ASME SFA 5.17
<b>Approvals</b>	CWB CSA W48 E49A3-EM12K-H8
<b>Industry</b>	Railcars Ship/Barge Building Tank and Vessel Fabrication Structural Steel Fabrication

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

### Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
Spoolarc 81	AWS A5.17: EM12K	F7A2-EM12K

### Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Spoolarc 81	As Welded ( )	460 MPa (67 ksi)	560 MPa (81 ksi)	27 %	38 J @ (28 ft-lb @ )

### Typical Weld Metal Analysis %

C	Mn	Si	S	P
<b>Spoolarc 81</b>				
0.08	1.40	0.30	0.01	0.02