

## OK Flux 281

OK Flux 281 is an active flux 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. \*Single pass application only. Any mechanical property and undiluted weld chemistry listed are for information only.

<b>Classifications</b>	AWS A5.17 : F7A0-EM13K AWS A5.17 : F7A0-EM12K ASME SFA 5.17
<b>Industry</b>	Pipe Construction Railcars Tank and Vessel Fabrication Metal Beam Fabrication

Classifications		
Wire	SFA/AWS - EN ISO	AWS - As Welded
Spoolarc 29S	AWS A5.17: EM13K	F7A0-EM13K
Spoolarc 81	AWS A5.17: EM12K	F7A0-EM12K

Typical Mechanical Properties					
Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Spoolarc 29S	As Welded ( )	615 MPa (89 ksi)	680 MPa (99 ksi)	22 %	31 J @ (23 ft-lb @ )
Spoolarc 81	As Welded ( )	540 MPa (78 ksi)	635 MPa (92 ksi)	25 %	20 J @ (28 ft-lb @ )

Typical Weld Metal Analysis %					
C	Mn	Si	S	P	
<b>Spoolarc 29S</b>					
0.07	1.80	1.00	0.01	0.02	
<b>Spoolarc 81</b>					
0.07	1.80	0.90	0.01	0.03	