

OK Flux 282

OK Flux 282 is an active, bonded flux designed for high speed, single pass welding of carbon steel sheet. Butt, lap, and fillet welds are well washed and free from undercut even at speeds up to 120 IPM (305 cm/min). It is primarily used with DC single and parallel wire systems at currents up to 1300 amps. OK Flux 282 is recommended for making high speed welds in metallic building beams, spiral pipe, storage tanks, and rail cars. *Single pass application only. Any mechanical property and undiluted weld chemistry listed are for information only.

Classifications	AWS A5.17 : F7AZ-EM13K AWS A5.17 : F7AZ-EM12K ASME SFA 5.17
Industry	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	F7AZ-EM13K
Spoolarc 81	AWS A5.17: EM12K	F7AZ-EM12K

Typical Mechanical Properties					
Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Spoolarc 29S	As Welded ()	605 MPa (88 ksi)	690 MPa (100 ksi)	22 %	19 J @ (14 ft-lb @)
Spoolarc 81	As Welded ()	585 MPa (85 ksi)	655 MPa (95 ksi)	23 %	24 J @ (18 ft-lb @)

Typical Weld Metal Analysis %					
C	Mn	Si	S	P	
Spoolarc 29S					
0.09	1.15	1.00	0.01	0.03	
Spoolarc 81					
0.09	1.24	0.80	0.02	0.03	