

OK Flux 350

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. It provides good performance at currents up to 1100 amps.

Classifications	AWS A5.17 : F7A2-EM13K AWS A5.17 : F7A2-EL12 AWS A5.17 : F7A2-EM12K ASME SFA 5.17
Approvals	CWB CSA W48 F49A3-EM12K-H8
Industry	Pressure Vessels Railcars Ship/Barge Building Tank and Vessel Fabrication

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

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
Spoolarc 29S	AWS A5.17: EM13K	F7A2-EM13K
Spoolarc 81	AWS A5.17: EM12K	F7A2-EM12K

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Spoolarc 29S	As Welded ()	490 MPa (71 ksi)	600 MPa (87 ksi)	28 %	32 J @ (24 ft-lb @)
Spoolarc 81	As Welded ()	455 MPa (66 ksi)	550 MPa (80 ksi)	26 %	42 J @ (31 ft-lb @)

Typical Weld Metal Analysis %

C	Mn	Si	S	P
Spoolarc 29S				
0.04	1.90	0.90	0.02	0.02
Spoolarc 81				
0.04	1.80	0.70	0.01	0.02