

SAW Backing Flux





AMA AP OP 10 U

Standards: DIN EN 760

~ ACS1

Type/ Characteristics: AMA OP 10 U is an agglomerated flux for use as the backing medium in the single-sided submerged arc welding process. For single-sided welding the backing flux is spread as a thin layer of a few millimeters in thickness in a copper backing bar which is pressed against the underside of the weld joint. After welding the slag detaches easily and the root of the weld exhibits a uniform profile. AMA OP 10 U is suitable for use with single, tandem and multi-wire submerged arc welding processes. The optimized fine grain size in combination with the flux chemistry of AMA OP 10 U ensures that the weld profile is straight, with clean weld toes and a smooth cosmetically acceptable surface. Damp flux should be redried by baking at 300-350C

Main constituents:

SiO₂ + TiO₂	CaO + MgO	Al₂O₃ + MnO	CaF₂
%32	%53	%5	%7

Packing: Polyethylene plastic sacks of 25 kg weight.