

Product Data Sheet

OK Autrod 12.22

S 'Submerged arc welding'

Prepared by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

EN 756 replaced by EN ISO 14171-A. TÜV approval for wire added. NAKS updated, Sepros taken out.

GENERAL

Copper-coated, unalloyed wire for Submerged Arc Welding. Suitable in combination with most fluxes. Increased Si content and thus especially suitable for neutral fluxes (e.g.: OK Flux 10.62) or in order to increase the fluidity of the molten pool. For structural steels, ship building steels, pressure vessel steels, fine grained steels, etc.

CLASSIFICATIONS Wire Electrode		APPROVALS	APPROVALS		
SFA/AWS A5.17	EM12K	CE	EN 13479		
EN ISO 14171-A	S2Si	DB	52.039.05		
		VdTÜV	12103		
		APPROVALS (SPECIFIC)			
		NAKS/HAKC	2.0, 2.5, 3.0, 4.0, 5,0mm	CZ	
		APPROVAL C	APPROVAL COMMENT		

All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

Wire/Strip (%)