



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 12.22

Signed by Lars Andersson	Approved by Martin Gehring/Christos Skodras	Reg no EN003642	Cancelling EN003239	Reg date 2006-11-03	Page 1 (1)
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REASON FOR ISSUE

Approvals: CE and NAKS added, Ü deleted.

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

EN 756 S2Si
SFA/AWS A5.17 EM12K

APPROVALS

CE EN 13479
DB 52.039.05
NAKS/HAKC 2,5 - 3,2 mm: CZ
Sepros UNA 347719
Comments: All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.08	0.12
Si	0.15	0.30
Mn	0.90	1.15
P		0.015
S		0.020