

OK AUTROD 12.33L

A copper-coated Mo alloyed solid wire for SAW



Classification AWS A5.23: EA 3 K

DESCRIPTION

OK AUTROD 12.33L is used for submerged arc welding and electroslag welding of unalloyed and low alloy steels with impact requirements higher than those obtainable with mild steel filler wires. Especially suitable for the two run technique.

TYPICAL WIRE COMPOSITION (%)

C	Mn	Si	S	P	Mo	Cu
0.10	1.80	0.55	0.018	0.018	0.5	0.25

TYPICAL WELDMETAL COMPOSITION WITH DIFFERENT FLUXES

Chemical Composition (%)					Mechanical Properties				
OK Autrod 12.33L/OK Flux	C	Mo	Mn	Si	Yield Stress N/mm ²	Tensile N/mm ²	El. (%)	Impacts values	
	J	Temp (°C)							
10.71L	0.10	0.5	1.7	0.4	530	630	26	40	-40
10.61L	0.09	0.5	1.85	0.2	600	750	25	45	-46

PACKING DATA

Size (mm)	Packing 25 Kg
2.00	✓
2.50	✓
3.15	✓
4.00	✓
5.00	✓

PACKING: The wires are packed in corrugated cardboard boxes.