

# OK AUTROD 12.40L

A copper-coated Mn alloyed semi killed wire for SAW



Classification      AWS A5.17: EH-14  
                               DIN 8557: S4

## DESCRIPTION

OK AUTROD 12.40L is a copper coated manganese alloyed semi-killed electrode for Submerged Arc Welding (SAW) of medium and high tensile steels.

**APPROVALS** : With OK FLUX 10.71L : LRS, IRS, DNV, RDSO, IBR

## TYPICAL WIRE COMPOSITION (%)

C	Mn	Si	S	P	Cu
0.12	1.8	0.08	0.018	0.018	0.25

## TYPICAL WELDMETAL COMPOSITION WITH DIFFERENT FLUXES

Chemical Composition (%)				Mechanical Properties				
OK Autrod 12.40L/OK Flux	C	Mn	Si	Yield Stress N/mm <sup>2</sup>	Tensile N/mm <sup>2</sup>	El. (%)	Impacts values	
							J	Temp (°C)
10.71L	0.10	1.6	0.30	480	570	26	40	-30
10.61L	0.10	1.7	0.20	540	630	26	40	-40
10.62L	0.10	1.8	0.20	540	630	25	50	-51

## PACKING DATA

Size (mm)	Packing 25 Kg	Packing 700 Kg
2.00	✓	x
2.50	✓	x
3.15	✓	✓
4.00	✓	✓
5.00	✓	x

PACKING: The wires are packed in corrugated cardboard boxes.