

OK AUTROD 12.08L

A copper coated mild steel wire for SAW



Classification AWS A5.17: EL-8

DESCRIPTION

OK AUTROD 12.08L is a copper-coated mild steel electrode for Submerged Arc Welding (SAW) of mild and medium carbon structural steels.

APPROVALS : OK AUTROD 12.08/OK FLUX 10.71L- LRS, ABS, IRS, BV, DNV
OK AUTROD 12.08/OK FLUX 10.81L- LRS, ABS, IRS, BV, DNV
OK AUTROD 12.08/OK FLUX 10.81LM- IRS, IBR

TYPICAL WIRE COMPOSITION (%)

C	Mn	Si	S	P	Cu
0.08	0.5	0.05	0.018	0.018	0.25

TYPICAL WELDMETAL COMPOSITION WITH DIFFERENT FLUXES

Chemical Composition (%)				Mechanical Properties				
OK Autrod 12.08L/OK Flux	C	Mn	Si	Yield Stress N/mm ²	Tensile N/mm ²	El. (%)	Impacts values	
							J	Temp (°C)
10.71L	0.08	1.0	0.25	360	430	28	40	-29
10.81L	0.07	1.2	0.30	460	530	25	50	0
10.81LM	0.07	1.2	0.35	460	530	25	40	0
10.81LS	0.07	1.2	0.35	460	530	25	40	0

PACKING DATA

Size (mm)	Packing 25 Kg	Packing 250 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 in case of 25 kg. packs.