

OK AUTROD 12.22L

A copper-coated semi killed wire for SAW



Classification AWS A5.17: EM-12K

DESCRIPTION

OK AUTROD 12.22L is a medium manganese alloyed copper coated steel wire for submerged arc welding and electroslag welding of medium and high tensile steels. Provides exceptional high impact values of submerged arc welds, when combined with fluxes like OK Flux 10.62L.

APPROVALS : OK AUTROD 12.22L /OK FLUX 10.71L- LRS, IBR
OK AUTROD 12.22L /OK FLUX 10.81LS- DNV

TYPICAL WIRE COMPOSITION (%)

C	Mn	Si	S	P	Cu
0.10	1.0	0.20	0.018	0.018	0.25

TYPICAL WELDMETAL COMPOSITION WITH DIFFERENT FLUXES

Chemical Composition (%)				Mechanical Properties				
OK Autrod 12.22L/OK Flux	C	Mn	Si	Yield Stress N/mm ²	Tensile N/mm ²	El. (%)	Impacts values	
							J	Temp (°C)
10.71L	0.08	1.3	0.45	420	520	27	50	-40
10.81LS	0.08	1.4	0.45	450	560	24	50	0
10.61L	0.07	1.2	0.30	420	510	27	45	-51
10.81L	0.07	1.3	0.35	450	540	24	45	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.