

OK AUTROD 12.24L



A copper-coated Mo alloyed solid wire for
SAW and electroslag welding



Classification AWS A5.23: EA 2

DESCRIPTION

OK AUTROD 12.24L 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.

APPROVALS : With OK FLUX 10.71L : RDSO

TYPICAL WIRE COMPOSITION (%)

C	Mn	Si	Mo	Cu	S	P
0.10	1.2	0.10	0.50	0.25	0.018	0.018

TYPICAL WELDMETAL COMPOSITION WITH DIFFERENT FLUXES

Chemical Composition (%)					Mechanical Properties				
OK Autrod 12.24 L/OK Flux	C	Mo	Mn	Si	Yield Stress N/mm ²	Tensile N/mm ²	El. (%)	Impacts values	
	J	Temp (°C)							
10.71L	0.08	0.4	1.4	0.4	520	590	24	30	-40
10.61L	0.07	0.45	1.0	0.5	520	600	26	40	-40
10.50	0.10	0.4	1.1	0.2	370	510	30	50	0

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.