



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 12.22

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

Approvals: UKCA added, NAKS deleted. General description amended

GENERAL

Copper-coated, unalloyed wire for Submerged Arc Welding. Well suitable to be combined with most fluxes. Increased Si content and thus recommended for neutral fluxes (e.g.: OK Flux 10.62) or in order to increase the fluidity of the molten pool. For structural steels, ship building steels, pressure vessel steels, fine grained steels, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.17 EM12K
EN ISO 14171-A S2Si

APPROVALS

CE EN 13479
DB 52.039.05
UKCA EN 13479
VdTÜV 12103

APPROVAL COMMENT

Other approvals: See Flux-Wire combinations.

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.08	0.12
Si	0.15	0.30
Mn	0.90	1.15
P		0.015
S		0.020