



# Product Data Sheet

S 'Submerged arc welding'

## OK Autrod 12.32

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

Approvals: UKCA and CWB added, NAKS deleted

### GENERAL

Copper-coated, unalloyed wire for Submerged Arc and Electroslag Welding. Increased Si content and thus especially suitable for neutral fluxes (e.g.: OK Flux 10.62) or in order to increase the fluidity of the molten pool. With OK Flux 10.62 excellent toughness values; CTOD tested. For structural steels, ship building steels, pressure vessel steels, fine grained steels, off-shore constructions, etc.

### CLASSIFICATIONS Wire Electrode

SFA/AWS A5.17    EH12K  
EN ISO 14171-A    S3Si

### APPROVALS

CE            EN 13479  
DB            52.039.12  
UKCA        EN 13479  
VdTÜV       12103

### APPROVALS (SPECIFIC)

CWB           F49A4-EH12K-H8           PV  
CWB           F49A4-EH12K-H4           PV  
                  BlockPac

### APPROVAL COMMENT

Other approvals: See Flux-Wire combinations.  
Approvals (Specific): Valid for wire with Lot numbers starting with prefix in right column.

### CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.11	0.15
Si	0.25	0.35
Mn	1.65	1.80
P		0.015
S		0.010