



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 13.43

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

Approvals: UKCA added

GENERAL

Ni-, Cr-, Mo-alloyed, copper-coated wire for Submerged Arc Welding. Preferably in combination with OK Flux 10.62. For high strength steels with minimum yield strengths up to 690 MPa, low temperature steels, fine grained steels, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23	EG
EN ISO 26304-A	S3Ni2,5CrMo
EN ISO 26304-B	(SUN4C1M3)

APPROVALS

CE	EN 13479
UKCA	EN 13479
VdTÜV	12104

APPROVAL COMMENT

Other approvals: See Flux-Wire combinations.

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.11	0.15
Si	0.10	0.25
Mn	1.40	1.60
P		0.020
S		0.020
Cr	0.55	0.85
Ni	2.20	2.60
Mo	0.40	0.70