



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 12.10

Signed by Lars Andersson	Approved by Martin Gehring/Christos Skodras	Reg no EN003639	Cancelling none	Reg date 2006-11-03	Page 1 (1)
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REASON FOR ISSUE

A new specification

GENERAL

Copper-coated, unalloyed wire for Submerged Arc Welding. For low requirements or in combination with high Si and Mn alloying fluxes. Suitable for non- and low alloyed steels.

CLASSIFICATIONS Wire Electrode

EN 756	S1
SFA/AWS A5.17	EL12

APPROVALS

CE	EN 13479
DB	52.039.01
Sepros	UNA 347719
Comments:	All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.06	0.12
Si		0.10
Mn	0.40	0.60
P		0.020
S		0.020