



Product Data Sheet

OK Flux 10.71/OK Autrod 12.20

S 'Submerged arc welding'

Signed by Lars Andersson	Approved by Martin Gehring/Christos Skodras	Reg no EN004087	Cancelling EN003966	Reg date 2007-09-13	Page 1 (2)
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REASON FOR ISSUE

Approvals: PRS added

GENERAL

Agglomerated aluminate-basic flux-wire-combination for Submerged Arc Welding. General purpose combination with excellent welding performance and very good operating characteristics. Impact toughness values down to -40°C. For structural steels, fine grained steels, pressure vessel steels, shipbuilding steels, line pipe steels, etc. Designed for single and multi wire procedures, for butt and fillet welds. Suitable for DC and AC welding. Single layer and multi layer welding of unlimited plate thickness.

CLASSIFICATIONS Flux

EN 760 SA AB 1 67 AC H5

CLASSIFICATIONS Weld Metal (as welded)

EN 756 S 38 4 AB S2

SFA/AWS A5.17 F7A4-EM12

CLASSIFICATIONS Weld Metal (PWHT)

SFA/AWS A5.17 F6P4-EM12

CLASSIFICATIONS Wire Electrode

EN 756 S2

SFA/AWS A5.17 EM12

APPROVALS

ABS 3M, 3YM

BV 3YM

CE EN 13479

DB 51.039.05 - 52.039.02

DNV IIIYM

GL 3YM

LR 3M, 3YM

VdTÜV 02552

APPROVALS (SPECIFIC)

PRS 3YM PL

RINA 3YM, 2YT HU

RS 3YM PL

CHEMICAL COMPOSITION

	All Weld Metal (%)				Wire/Strip (%)	
	DC+, 580A, 29V		AC, 580A, 29V		Min	Max
	Max	Nom	Max	Nom		
C		0.05		0.06	0.08	0.12
Si		0.3		0.2		0.10
Mn		1.35		1.2	0.90	1.15
P	0.03		0.03			0.020
S	0.02		0.02			0.020



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MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal								
	AWS DC+			AWS DC+			EN AC		
	As welded			Stress relieved 620°C 1.0h			As welded		
	Min	Max	Typ	Min	Max	Typ	Min	Max	Typ
Rp0.2 (MPa)	400		410	330		390			
ReL (MPa)							380		425
ReH (MPa)									430
Rm (MPa)	480	650	510	415	550	500	470	600	535
A4-A5 (%)	22		29	22		30	20		33
Z (%)			69			65			70
Charpy V at 20°C (J)			135			100			150
Charpy V at 0°C (J)			125			90			130
Charpy V at -20°C (J)			80			55			115
Charpy V at -40°C (J)	27		55	27		30	47		70