



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 12.24

Prepared by M Gustafsson	Approved by Martin Gehring/Christos Skodras	Reg no EN005441	Cancelling EN004386	Reg date 2011-06-17	Page 1 (1)
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REASON FOR ISSUE

EN 756 replaced by EN ISO 14171-A. TÜV approval for wire added. NAKS updated.

GENERAL

Mo-alloyed, copper-coated wire for Submerged Arc Welding. For creep resistant steels (0,5% Mo), structural steels, ship building steels, pressure vessel steels, pipeline steels up to X70, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23	EA2
EN ISO 14171-A	S2Mo
EN ISO 24598-A	S Mo

APPROVALS

CE	EN 13479
DB	52.039.06
VdTÜV	12103

APPROVALS (SPECIFIC)

NAKS/HAKC	2.0, 2.5, 3.0, 4.0, 5.0mm	CZ
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APPROVAL COMMENT

All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.08	0.12
Si	0.05	0.20
Mn	0.95	1.20
P		0.020
S		0.020
Mo	0.45	0.60