



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 12.20

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REASON FOR ISSUE

NAKS approval added.

GENERAL

Copper-coated, unalloyed wire for Submerged Arc and Electroslag Welding. Suitable in combination with most fluxes. For structural steels, ship building steels, pressure vessel steels, fine grained steels, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.17 EM12
EN ISO 14171-A S2

APPROVALS

CE EN 13479
DB 52.039.02
VdTÜV 12103

APPROVALS (SPECIFIC)

NAKS/HAKC 3.0, 4.0 mm CZ

APPROVAL COMMENT

All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C	0.08	0.12
Si		0.10
Mn	0.90	1.15
P		0.020
S		0.020