



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 12.34

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006296	Cancelling EN006227	Reg date 2013-11-26	Page 1 (1)
-------------------------------	------------------------------	-------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

Classification EN ISO 24598-A corrected.

GENERAL

Mo-alloyed, copper-coated wire for Submerged Arc and Electroslag Welding. For creep resistant steels (0,5% Mo), structural steels, ship building steels, pressure vessel steels, pipeline steels up to X80, high strength steels, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23	EA4
EN ISO 14171-A	S3Mo
EN ISO 24598-A	S S MnMo

APPROVALS

VdTÜV 12103

APPROVALS (SPECIFIC)

NAKS/HAKC 4.0 mm CZ

APPROVAL COMMENT

All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C	0.10	0.15
Si	0.05	0.20
Mn	1.30	1.65
P		0.015
S		0.015
Mo	0.45	0.60