



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 13.20 SC

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REASON FOR ISSUE

General description corrected (Bruscato factor).

GENERAL

Cr-, Mo-alloyed, copper-coated wire for Submerged Arc Welding. Very low level of impurities. X-factor (Bruscato-) max. 11. With OK Flux 10.63 for highest toughness requirements also after Step-Cooling; very clean weld metal with X-factor max. 15. Mainly for creep resistant steels (2,25% Cr, 1% Mo).

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23 EB3R
EN ISO 24598-A S S CrMo2

APPROVALS

CE EN 13479
VdTÜV 12104

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	0.07	0.20
Mn	0.55	0.70
P		0.010
S		0.010
Cr	2.25	2.50
Ni		0.15
Mo	0.90	1.10
V		0.01
Nb		0.01
Cu		0.15
Sn		0.005
As		0.005
Sb		0.005
X		11

Comments:

$X = (10P+5Sb+4Sn+As) / 100$
(values in ppm)

Cu: including the copper coating.