



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 13.27

Prepared by Solveig Rigdal	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006302	Cancelling EN005550	Reg date 2013-11-26	Page 1 (1)
-------------------------------	------------------------------	-------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

NAKS approval deleted.

GENERAL

Ni-alloyed, copper-coated wire for Submerged Arc Welding. With OK Flux 10.62 excellent toughness values; CTOD tested. For low temperature steels and fine grained steels in ship building, Off-Shore, pressure vessel industries, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23 ENi2
EN ISO 14171-A S2Ni2

APPROVALS

CE EN 13479
DB 52.039.08
VdTÜV 12103

APPROVAL COMMENT

All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.07	0.12
Si	0.10	0.25
Mn	0.80	1.20
P		0.010
S		0.010
Ni	2.10	2.40