



# Product Data Sheet

S 'Submerged arc welding'

# OK Autrod 13.35

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## REASON FOR ISSUE

Chemical composition: Maximum limit for Al and for Mn+Ni added.

## GENERAL

Cr-, Mo-alloyed, non copper-coated wire for Submerged Arc Welding. Mainly for creep resistant steels (9% Cr, 1% Mo V Nb).

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23 EB91  
EN ISO 24598-A S S CrMo91

## APPROVALS

VdTÜV 12104

## APPROVAL COMMENT

All others: See Flux-Wire combinations

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Min	Max
C	0.07	0.13
Si	0.10	0.30
Mn	0.40	0.70
P		0.010
S		0.010
Cr	8.50	10.00
Ni	0.40	1.00
Mo	0.85	1.10
V	0.15	0.25
Nb	0.03	0.10
Cu		0.10
Al		0.04
N	0.03	0.07

Comments:

Mn+Ni = max 1.3