



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 13.36

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REASON FOR ISSUE

EN 756 replaced by EN ISO 14171-A. TÜV approval for wire added.

GENERAL

Ni-, Cu-, Cr-alloyed, copper-coated wire for Submerged Arc Welding. For weather resistant steels such as COR-TEN, Patinax, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23 EG
EN ISO 14171-A S2Ni1Cu

APPROVALS

CE EN 13479
DB 52.039.04
VdTÜV 12103

APPROVAL COMMENT

All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.08	0.12
Si	0.15	0.35
Mn	0.70	1.20
P		0.020
S		0.020
Cr	0.20	0.40
Ni	0.65	0.90
Cu	0.40	0.60

Comments:
Cu: including the copper coating.