



# Product Data Sheet

S 'Submerged arc welding'

# OK Autrod 13.40

Prepared by Fredrik Wedberg	Qualified by Tero Tolonen	Approved by Martin Gehring	Reg no EN006231	Cancelling EN005552	Reg date 2013-10-10	Page 1 (1)
--------------------------------	------------------------------	-------------------------------	--------------------	------------------------	------------------------	---------------

## REASON FOR ISSUE

NAKS approval updated.

## GENERAL

Ni-, Mo-alloyed, copper-coated wire for Submerged Arc Welding. Preferably in combination with OK Flux 10.62. For high strength steels with minimum yield strengths up to 620 MPa, low temperature steels, fine grained steels, etc.

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23	EG
EN ISO 14171-A	S3Ni1Mo
EN ISO 26304-A	S3Ni1Mo
EN ISO 26304-B	(SUN2M2)

## APPROVALS

CE	EN 13479
VdTÜV	12103

## APPROVALS (SPECIFIC)

NAKS/HAKC	3.2mm, 4.0 mm	CZ
-----------	---------------	----

## APPROVAL COMMENT

All others: See Flux-Wire combinations

## CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.08	0.14
Si	0.10	0.25
Mn	1.40	1.70
P		0.015
S		0.010
Ni	0.80	1.00
Mo	0.45	0.60