



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 13.43

Prepared by Fredrik Wedberg	Approved by Martin Gehring/Christos Skodras	Reg no EN005553	Cancelling EN003832	Reg date 2011-09-16	Page 1 (1)
--------------------------------	--	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

EN 14295 replaced by EN ISO 26304-A and -B. TÜV approval for wire added, Sepros taken out.

GENERAL

Ni-, Cr-, 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 690 MPa, low temperature steels, fine grained steels, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23	EG
EN ISO 26304-A	S3Ni2,5CrMo
EN ISO 26304-B	(SUN4C1M3)

APPROVALS

CE	EN 13479
VdTÜV	12104

APPROVAL COMMENT

All others: See Flux-Wire combinations

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.11	0.15
Si	0.10	0.25
Mn	1.40	1.60
P		0.020
S		0.020
Cr	0.55	0.85
Ni	2.20	2.60
Mo	0.40	0.70