



Product Data Sheet

S 'Submerged arc welding'

OK Autrod 13.64

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REASON FOR ISSUE

AWS classification, chemical composition (Mo) and General text modified.

GENERAL

Low-alloyed and Ti-B micro-alloyed, copper-coated solid wire for Submerged Arc Welding. Especially for high dilution welds where low temperature impact toughness properties are required. For fine grained steels, pipeline steels, ship building steels, etc.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.23 EA2TiB
EN ISO 14171-A S2MoTiB

APPROVALS

VdTÜV 12103

APPROVALS (SPECIFIC)

NAKS/HAKC 3.0, 4.0, 5.0mm CZ

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C	0.05	0.15
Si	0.15	0.35
Mn	1.10	1.30
P		0.025
S		0.025
Mo	0.45	0.60
Ti	0.10	0.20
B	0.010	0.020