

OK AUTROD 12.34L

A Mn-Mo alloyed copper-coated wire for
SAW and electroslag welding



Classification AWS A5.23: EA 4

DESCRIPTION

OK AUTROD 12.34L is manganese - molybdenum alloyed copper-coated electrode for submerged arc welding and electroslag welding of high tensile steels and steels for low temperature application.

TYPICAL WIRE COMPOSITION (%)

| C | Mn | Si | Mo | Cu | S | P |
|------|-----|------|------|------|-------|-------|
| 0.12 | 1.5 | 0.15 | 0.50 | 0.25 | 0.018 | 0.018 |

TYPICAL WELDMETAL COMPOSITION WITH DIFFERENT FLUXES

| Chemical Composition (%) | | | | | Mechanical Properties | | | | |
|----------------------------------|------|------|-----|-----|-----------------------------------|------------------------------|------------|----------------|-----------|
| OK Autrod 12.34 L/ OK Flux | C | Mo | Mn | Si | Yield Stress N/mm ² | Tensile N/mm ² | El. (%) | Impacts values | |
| | | | | | | | | J | Temp (°C) |
| 10.71L | 0.09 | 0.45 | 1.5 | 0.4 | 550 | 640 | 25 | 50 | -40 |
| 10.61L | 0.10 | 0.40 | 1.4 | 0.2 | 580 | 660 | 24 | 60 | -40 |

PACKING DATA

| Size (mm) | Packing 25 Kg |
|--------------|------------------|
| 2.00 | ✓ |
| 2.50 | ✓ |
| 3.15 | ✓ |
| 4.00 | ✓ |
| 5.00 | ✓ |

PACKING: The wires are packed in corrugated cardboard boxes.