

## OK Autrod B2 SC

Cr-, Mo-alloyed, copper-coated wire for Submerged Arc Welding. Very low level of impurities. X-bar (Bruscato-) max. 7. With OK Flux 10.66 for highest toughness requirements also after Step-Cooling; very clean weld metal with X-bar max. 10. Mainly for creep resistant steels (1,25% Cr, 0,5% Mo).

| Specifications  |                                                    |
|-----------------|----------------------------------------------------|
| Classifications | SFA/AWS A5.23 : EB2R<br>EN ISO 24598-A : S S CrMo1 |
| Approvals       | CE : EN 13479<br>UKCA : EN 13479                   |

Approvals are based on factory location. Please contact ESAB for more information.

| Typical Wire Composition % |      |      |       |       |      |      |      |       |       |
|----------------------------|------|------|-------|-------|------|------|------|-------|-------|
| C                          | Mn   | Si   | S     | P     | Ni   | Cr   | Mo   | V     | Al    |
| 0.10                       | 0.65 | 0.12 | 0.003 | 0.004 | 0.06 | 1.20 | 0.50 | 0.005 | 0.005 |

| Typical Wire Composition % |       |       |       |       |        |       |       |         |       |
|----------------------------|-------|-------|-------|-------|--------|-------|-------|---------|-------|
| Cu                         | Nb    | Ti    | Sb    | As    | B      | Sn    | Mn+Si | Nb+Ti+V | P+Sn  |
| 0.08                       | 0.004 | 0.002 | 0.002 | 0.003 | 0.0005 | 0.002 | 0.77  | 0.011   | 0.006 |

| Typical Wire Composition % |       |
|----------------------------|-------|
| J-Factor                   | X-bar |
| 50                         | 5     |