

OK Tubrod 15.00

A basic cored wire for use with M21 or C1 shielding gas. Diameters less than 1.4mm are all-positional.

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|------------------------|---|
| Classifications | SFA/AWS A5.20 : E71T-5C H4 SFA/AWS A5.20 : E71T-5M H4 EN ISO 17632-A : T 42 3 B C1 2 H5 EN ISO 17632-A : T 42 3 B M21 2 H5 |
| Approvals | CE : EN 13479 DB : 42.039.12 DNV : III YMS (M21) GL : 3Y H10S LR : 3YS H5 (M21) RINA : 3YS H5 (M21) VdTÜV : 02181 |

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|----------------------------|-------------|
| Welding Current | DC- |
| Diffusible Hydrogen | < 4 ml/100g |
| Alloy Type | C Mn |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|-----------------------------|----------------|------------------|------------|
| M21 shielding gas EN | | | |
| As Welded | 456 MPa | 569 MPa | 28 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------------------------|---------------------|--------------|
| M21 shielding gas EN | | |
| As Welded | -30 °C | 129 J |
| As Welded | -20 °C | 145 J |

Typical Weld Metal Analysis %

| C | Mn | Si |
|--------------------------|------|------|
| M21 shielding gas | | |
| 0.06 | 1.44 | 0.70 |

Deposition Data

| Diameter | Current | Voltage | Wire Feed Speed | Deposition Rate |
|----------|-----------|---------|-----------------|-----------------|
| 1.0 mm | 100-230 A | 14-30 V | 4.5-13.0 m/min | 1.2-4.0 kg/h |
| 1.2 mm | 120-300 A | 16-32 V | 4.0-15.0 m/min | 1.7-6.5 kg/h |
| 1.4 mm | 130-350 A | 16-32 V | 3.0-12.0 m/min | 1.5-7.5 kg/h |
| 1.6 mm | 140-400 A | 24-34 V | 3.0-10.5 m/min | 2.0-8.0 kg/h |
| 2.4 mm | 250-500 A | 28-38 V | 1.5-6.0 m/min | 3.5-9.5 kg/h |