

OK Tubrod 15.14

OK Tubrod 15.14 is a flux-cored, tubular wire for all-positional welding using either Ar/CO₂ or CO₂. The wire is suitable for all mild and medium tensile structural steels. The running characteristics are exceptional, using the spray mode of transfer, and this applies equally to both shielding gases. OK Tubrod 15.14 is also universally approved to grade 3 by all major authorities. Shielding gas Ar/20%CO₂ or CO₂.

Classifications Weld Metal	SFA/AWS A5.20 : E71T-1M SFA/AWS A5.20 : E71T-1C EN ISO 17632-A : T 46 2 P C1 1 H5 EN ISO 17632-A : T 46 2 P M21 2 H5
Approvals	ABS 3YSA H5 (C1 & M21) BV SA3YM (C1) BV SA3YM (M21) CE EN 13479 DB 42.039.05 (M21 and C1) DNV III YMS H5 (C1) DNV-GL III YMS (M21) LR 3YS H5 (C1 & M21) LR 3YS H5 (M21)* NAKS/HAKC 1.2 mm PRS 3YS H10 (C1 & M21) RINA 2Y S H5 (C1) RS 3YMS H5 (C1) RS 3YSH5 (C1 & M21) VdTUV 07651

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

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	C Mn

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
As Welded	497 MPa	588 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-20 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si
0.05	1.30	0.54

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	110-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h
1.4 mm	130-320 A	22-32 V	3.0-12.5 m/min	1.4-6.3 kg/h
1.6 mm	150-360 A	24-34 V	3.0-11.0 m/min	2.0-6.2 kg/h