OK Tubrod 15.14

A multi-purpose all positional rutile cored wire for use with C1 or M21 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

Specifications	
Classifications	SFA/AWS A5.20 : E71T-1C H8 SFA/AWS A5.20 : E71T-1M H8 EN ISO 17632-A : T 46 2 P C1 1 H5 EN ISO 17632-A : T 46 3 P M21 2 H5
Approvals	ABS : 3YSA H5 (C1, M21) BV : SA3YM (C1, M21) CE : EN 13479 DB : 42.039.05 DNV : III YMS (C1, M21) LR : 3YM H5 LR : 3YS H5 PRS : 3YS H10 (C1, M21) RINA : 2YS H5 RINA : 3YS H5 UKCA : EN 13479 VdTÜV : 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
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS C1			
PWHT 3 hour(s) 620 °C	523 MPa	601 MPa	25.4 %
C1			
As Welded	497 MPa	588 MPa	27 %
M21			
As Welded	590 MPa	661 MPa	23 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS C1		
PWHT 3 hour(s) 620 °C	-20 °C	166 J
C1		
As Welded	-20 °C	110 J
M21		
As Welded	-20 °C	120 J
As Welded	-30 °C	90 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
C1 Shielding gas		
0.05	1.31	0.31

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Typical Weld Metal Analysis %		
C	**Mn**	**Si**
M21 shielding gas		
0.06	1.40	0.40

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