

OK Tubrod 15.27

A basic cored wire for welding steels with a minimum yield strength of 690 MPa for use with Ar/CO₂ shielding gas.

Specifications

Classifications	SFA/AWS A5.36 : E110T5-M21A6-G EN ISO 18276-A : T 69 5 Mn2.5Ni B M21 3 H5
Welding Current	DC-
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Low alloy high strength steel (HY100)
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	750 MPa	820 MPa	21 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-50 °C	80 J
As Welded	-40 °C	120 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.06	1.6	0.5	2.5

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	120-300 A	16-32 V	4.0-15.0 m/min	1.7-6.5 kg/h