

OK Tubrod 15.19

An all-positional rutile cored wire for welding steels with a minimum yield strength of 550 Mpa, for use with M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E81T1-Ni1M EN ISO 17632-A : T 50 5 Z P M21 2 H5
Approvals	MoD : Q1N NAKS/HAKC : 1.2 mm

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

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Low alloy steel (1% Ni)
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	604 MPa	663 MPa	26 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-50 °C	106 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
M21 shielding gas									
0.05	1.45	0.41	0.011	0.008	1.00	0.02	0.01	0.02	0.01

Typical Weld Metal Analysis %

Nb
M21 shielding gas
0.02

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h