

OK Tubrod 14.11

A metal cored wire for robotic or automated welding of single and multi-pass fillet welds using M21 and M12 shielding gas. Used in the downhand and horizontal / vertical positions.

Specifications

Classifications	SFA/AWS A5.18 : E70C-6M H4 EN ISO 17632-A : T 42 4 M M21 3 H5
Approvals	ABS : 4Y400SA H5 BV : S3YMH5 BV : S3YM H5 CE : EN 13479 DB : 42.039.28 DNV : IV Y40(H5) DNV-GL : IV Y40(H5) LR : 4Y40M H5 LR : 4Y40S H5 UKCA : EN 13479 VdTÜV : 10010

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

Welding Current	DC+
Alloy Type	C Mn
Shielding Gas	M12, M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21			
As Welded	453 MPa	558 MPa	32 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21		
As Welded	-40 °C	55 J

Typical Weld Metal Analysis %

C	Mn	Si
Shielding gas: M21		
0.048	1.45	0.64
Shielding gas: M12		
0.050	1.9	0.9

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	100-350 A	14-32 V	1.8-18.5 m/min	1.3-8.0 kg/h
1.4 mm	150-350 A	18-33 V	3.5-12.1 m/min	2.1-7.2 kg/h