

OK Tubrod 14.13

A general purpose metal cored wire for use with M21 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

Specifications

Classifications	SFA/AWS A5.18 : E70C-6M EN ISO 17632-A : T 42 2 M M21 2 H5
Approvals	ABS : 3YSA H5 BV : SA3YM CE : EN 13479 DB : 42.039.03 DNV-GL : III YMS LR : 3YS H5 UKCA : EN 13479 VdTÜV : 09086

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 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas EN			
As Welded	503 MPa	611 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas EN		
As Welded	-29 °C	85 J
As Welded	-20 °C	106 J

Typical Weld Metal Analysis %

C	Mn	Si
M21 Shielding gas		
0.08	1.51	0.63

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-320 A	16-32 V	1.8-12.0 m/min	1.3-7.5 kg/h
1.4 mm	120-380 A	16-34 V	2.0-9.0 m/min	1.6-7.5 kg/h
1.6 mm	140-450 A	18-36 V	1.5-8.5 m/min	1.6-8.0 kg/h