

OK Tubrod 15.00

A basic cored wire for use with M21 or C1 shielding gas. Diameters less than 1.4mm are all-positional.

Specifications

Classifications	SFA/AWS A5.20 : E71T-5C H4 SFA/AWS A5.20 : E71T-5M H4 EN ISO 17632-A : T 42 3 B C1 2 H5 EN ISO 17632-A : T 42 3 B M21 2 H5
Approvals	CE : EN 13479 DB : 42.039.12 DB : 81.039.03 DNV-GL : III YMS(H5) LR : 3YS H5 (M21) RINA : 3Y S H5 (M21) UKCA : EN 13479 VdTÜV : 02181

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

Welding Current	DC-
Diffusible Hydrogen	< 4 ml/100g
Alloy Type	C Mn
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas EN			
As Welded	456 MPa	569 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas EN		
As Welded	-30 °C	129 J
As Welded	-20 °C	145 J

Typical Weld Metal Analysis %

M21 shielding gas

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-230 A	14-30 V	4.5-13.0 m/min	1.2-4.0 kg/h
1.2 mm	120-300 A	16-32 V	4.0-15.0 m/min	1.7-6.5 kg/h
1.4 mm	130-350 A	16-32 V	3.0-12.0 m/min	1.5-7.5 kg/h
1.6 mm	140-400 A	24-34 V	3.0-10.5 m/min	2.0-8.0 kg/h
2.4 mm	250-500 A	28-38 V	1.5-6.0 m/min	3.5-9.5 kg/h