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)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 shielding gas			
As Welded	604 MPa	663 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**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	**Current**	**Voltage**	**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