

OK Tubrodur 13Cr G

A cored wire which produces a 13%-chromium alloy steel deposit used with M13, M21 or C1 shielding gas.

Specifications

Classifications	EN 14700 : T Z Fe7
Approvals	NAKS/HAKC : 1.6 mm

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

Welding Current	DC+
Alloy Type	Martensitic stainless steel weld metal
Shielding Gas	M12, M13, M21, C1 (EN ISO 14175)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	V	Nb
M21 shielding gas							
0.15	1.14	0.31	2.23	12.53	1.40	0.23	0.23

Recommended Welding Parameters

Current	Wire Diameter	Voltage
200-260 A	1.6 mm	28-30 V