

OK Tubrod 15.13

A multi-purpose all positional rutile cored wire for use with C1 or M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C H4 SFA/AWS A5.20 : E71T-1M H8 EN ISO 17632-A : T 42 3 P C1 1 H5 EN ISO 17632-A : T 46 4 P M21 1 H5
Approvals	ABS : 3YSA H5 ABS : 4YSA H10 BV : SA3M, SA3YM H5, A3M, A3YM H5 (C1) BV : SA4YM H10, A4YM H10 CE : EN 13479 DB : 42.039.21 DNV-GL : III YMS(H5) (C1) LR : 3YS H5 (C1) LR : 4YS H10 (M21) PRS : 3YS H5 (C1) PRS : 4YS H10 (M21) RINA : 2Y S H5 RINA : 4Y S H10 UKCA : EN 13479 VdTÜV : 05019

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

Welding Current	DC+
Alloy Type	C Mn
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	550 MPa	620 MPa	26 %
C1 shielding gas			
As Welded	535 MPa	601 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-40 °C	70 J
C1 shielding gas		
As Welded	-30 °C	65 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P
Shielding Gas C1				
0.059	1.33	0.63	0.009	0.012

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-300 A	22-35 V	4.5-23.0 m/min	1.2-6.2 kg/h
1.2 mm	150-350 A	23-35 V	5.8-20.7 m/min	2.1-7.5 kg/h

MILD STEEL

GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)



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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.4 mm	150-350 A	22-34 V	3.3-11.6 m/min	1.8-6.3 kg/h
1.6 mm	150-450 A	22-36 V	2.8-12.4 m/min	1.8-8.1 kg/h