

OK Tubrod 14.10

A metal cored wire suitable for the welding of thin plate (>3mm) using M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.18 : E70C-6M H4 EN ISO 17632-A : T 46 4 M M21 2 H5
Approvals	CE : EN 13479 DB : 42.039.22 DNV : IV YMS(H5) DNV-GL : IV YMS(H5) LR : 4Y46M LR : 4Y46S UKCA : EN 13479 VdTÜV : 05018

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	485 MPa	570 MPa	28.9 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-40 °C	75 J

Typical Weld Metal Analysis %

C	Mn	Si
M21 shielding gas		
0.075	1.55	0.65

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	130-350 A	16-34 V	4.6-18.5 m/min	2.0-8.0 kg/h