

OK Tubrod 15.06

A basic cored wire which gives good toughness down to -60 °C for use with M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E71T5-K6M H4 EN ISO 17632-A : T 42 6 1Ni B M21 1 H5
Approvals	CE : EN 13479 DB : 42.039.25 UKCA : EN 13479 VdTÜV : 05647

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

Welding Current	DC-(+)
Alloy Type	Low alloy 1% Ni
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	445 MPa	556 MPa	28 %
PWHT 2 hour(s) 600 °C	425 MPa	535 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-60 °C	109 J
PWHT	-60 °C	60 J
PWHT	-40 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.084	1.24	0.45	0.85

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	20-35 V	5.8-22.0 m/min	2.1-7.9 kg/h
1.6 mm	150-450 A	18-36 V	2.8-12.0 m/min	1.8-7.9 kg/h