

## OK Tubrod 15.22

A basic cored wire for welding 2.25%Cr 1% Mo creep resisting steels using M21 shielding gas.

### Specifications

|                            |                                                |
|----------------------------|------------------------------------------------|
| <b>Classifications</b>     | SFA/AWS A5.29 : E90T5-B3                       |
| <b>Welding Current</b>     | DC-                                            |
| <b>Diffusible Hydrogen</b> | < 5 ml/100g                                    |
| <b>Alloy Type</b>          | Creep resisting low alloy steel (2% Cr, 1% Mo) |
| <b>Shielding Gas</b>       | M21 (EN ISO 14175)                             |

### Typical Tensile Properties

| Condition                    | Yield Strength | Tensile Strength | Elongation |
|------------------------------|----------------|------------------|------------|
| <b>AWS M21 shielding gas</b> |                |                  |            |
| PWHT 675DegC 1h<br>1 hour(s) | 605 MPa        | 685 MPa          | 22 %       |

### Typical Weld Metal Analysis %

| C                        | Mn   | Si   | Cr   | Mo   |
|--------------------------|------|------|------|------|
| <b>M21 shielding gas</b> |      |      |      |      |
| 0.06                     | 0.95 | 0.52 | 2.32 | 0.99 |

### Deposition Data

| Diameter | Current   | Voltage | Wire Feed Speed | Deposition Rate |
|----------|-----------|---------|-----------------|-----------------|
| 1.2 mm   | 120-300 A | 16-32 V | 4.0-15.0 m/min  | 1.7-6.5 kg/h    |