

## OK Tubrod 15.15

A positional rutile cored wire for use with C1 or M21 shielding gas.

### Specifications

|                        |                                                                                                                                                                                                          |
|------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.20 : E71T-1C<br>SFA/AWS A5.20 : E71T-1M<br>EN ISO 17632-A : T 46 2 P C1 1 H5<br>EN ISO 17632-A : T 46 2 P M21 2 H5                                                                            |
| <b>Approvals</b>       | ABS : 3YSA H5 (M21,C1)<br>BV : 3YS H5 (C1)<br>BV : 3YS H5 (M21)<br>CE : EN 13479<br>DB : 42.039.14<br>DNV : III YMS(H5)<br>LR : 3YS H5 (M21,C1)<br>NAKS/HAKC : 1.2mm<br>UKCA : EN 13479<br>VdTÜV : 04175 |

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

|                            |                                     |
|----------------------------|-------------------------------------|
| <b>Welding Current</b>     | DC+                                 |
| <b>Diffusible Hydrogen</b> | < 5 ml/100g (<10 ml/100g for 1.6mm) |
| <b>Alloy Type</b>          | C Mn                                |
| <b>Shielding Gas</b>       | M21, C1 (EN ISO 14175)              |

### Typical Tensile Properties

| Condition                | Yield Strength | Tensile Strength | Elongation |
|--------------------------|----------------|------------------|------------|
| <b>C1 AWS</b>            |                |                  |            |
| PWHT<br>3 hour(s) 620 °C | 523 MPa        | 601 MPa          | 25.4 %     |
| <b>C1 EN</b>             |                |                  |            |
| As Welded                | 497 MPa        | 588 MPa          | 27 %       |
| <b>M21 EN</b>            |                |                  |            |
| As Welded                | 590 MPa        | 661 MPa          | 23 %       |

### Typical Charpy V-Notch Properties

| Condition     | Testing Temperature | Impact Value |
|---------------|---------------------|--------------|
| <b>C1 AWS</b> |                     |              |
| PWHT          | -20 °C              | 166 J        |
| <b>C1 EN</b>  |                     |              |
| As Welded     | -20 °C              | 110 J        |
| <b>M21 EN</b> |                     |              |
| As Welded     | -30 °C              | 90 J         |
| As Welded     | -20 °C              | 120 J        |

### Typical Weld Metal Analysis %

| C                        | Mn   | Si   |
|--------------------------|------|------|
| <b>M21 shielding gas</b> |      |      |
| 0.06                     | 1.40 | 0.40 |
| <b>C1 shielding gas</b>  |      |      |
| 0.05                     | 1.31 | 0.31 |

MILD STEEL

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



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### Deposition Data

| Diameter | Current   | Voltage | Wire Feed Speed | Deposition Rate |
|----------|-----------|---------|-----------------|-----------------|
| 1.2 mm   | 100-300 A | 20-30 V | 3.2-14.5 m/min  | 1.3-5.8 kg/h    |
| 1.6 mm   | 150-360 A | 24-34 V | 3.0-11.0 m/min  | 2.0-6.2 kg/h    |