OK Tubrod 15.09

An all-positional rutile cored wire for welding high strength steel with a minimum yield strength of 690 MPa for use with M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E111T1-K3MJ-H4 EN ISO 18276-A : T 69 4 2NiMo P M21 2 H5
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 10733

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

Welding Current	DC+
Alloy Type	Low Alloy (Ni Mo)
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 shielding gas			
As Welded	761 MPa	840 MPa	20 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
M21 shielding gas		
As Welded	-40 °C	60 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Ni**	**Mo**
0.055	1.21	0.39	2.3	0.4

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	150-350 A	21-32 V	5.6-19.8 m/min	2.1-7.5 kg/h