

OK Tubrod 14.05

A 1% Ni metal cored wire which gives good toughness down to -40 degrees C using M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.28 : E70C-GM EN ISO 17632-A : T 42 4 Z M M21 2 H5
Approvals	ABS : 3YSA H10 (M21) BV : SA3YM HH (M21) CE : EN 13479 DNV-GL : III YMS(H10) LR : 4Y40S H5 (M21) UKCA : EN 13479

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

Welding Current	DC+-
Diffusible Hydrogen	<5 ml/100g
Alloy Type	Low alloy steel - (1% Ni)
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	501 MPa	601 MPa	27 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-40 °C	80 J
As Welded	-20 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.05	1.36	0.52	0.91

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.0 mm	80-250 A	14-30 V	2.5-10.0 m/min	1.2-4.2 kg/h
1.2 mm	100-320 A	16-32 V	1.8-12.0 m/min	1.3-7.5 kg/h