

OK Tubrod 14.03

A metal cored wire for high strength applications (>690 Mpa) for use with M21 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

Specifications

Classifications	SFA/AWS A5.28 : E110C-G SFA/AWS A5.29 : E111TG-K3 EN ISO 18276-A : T 69 4 Mn2NiMo M M21 2 H5
Approvals	CE : EN 13479 DB : 42.039.23 UKCA : EN 13479 VdTÜV : 04142

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

Welding Current	DC+-
Diffusible Hydrogen	< 5ml/100g
Alloy Type	C Mn, low alloy steel (2% Ni, 0.5% Mo)
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21			
As Welded	757 MPa	842 MPa	20 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21		
As Welded	-40 °C	71 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
M21 shielding gas				
0.07	1.60	0.50	2.25	0.56

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-320 A	16-32 V	1.8-12.0 m/min	1.3-7.5 kg/h
1.4 mm	120-380 A	16-34 V	2.0-9.0 m/min	1.6-7.5 kg/h
1.6 mm	140-450 A	18-36 V	1.5-8.5 m/min	1.6-8.0 kg/h