

OK Tubrod 14.00S

A metal cored wire for submerged arc welding.

Specifications

Classifications	EN ISO 14174 : SA AB 1 67 AC H5 SFA/AWS A5.17 : F7A2-EC1
Approvals	ABS : 3YM (10.71) BV : 3YM (10.71) CE : EN 13479 (10.71) CE : EN 13479 DB : 52.039.13 - 51.039.05 (10.71) DNV : III YM (10.71) GL : 3YM (10.71) LR : 3YM (10.71) VdTÜV : 09143 (10.71)

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

Welding Current	DC+, AC
Diffusible Hydrogen	< 10 ml/100g
Alloy Type	C Mn

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
EN with OK Flux 10.71			
As Welded	454 MPa	538 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
EN with OK Flux 10.71		
As Welded	-20 °C	132 J

Typical Weld Metal Analysis %

C	Mn	Si
with OK Flux 10.71		
0.06	1.52	0.47

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
2.4 mm	250-450 A	28-38 V	2.0-5.0 m/min	4.0-9.0 kg/h
3.0 mm	400-700 A	28-40 V	2.5-5.5 m/min	5.5-12.0 kg/h
4.0 mm	500-850 A	28-40 V	2.0-5.0 m/min	6.5-12.5 kg/h