

OK Tubrod 15.16

A high deposition downhand rutile cored wire for use with C1 shielding gas.

Specifications

Classifications	SFA/AWS A5.20 : E70T-1C EN ISO 17632-A : T 42 0 R C 3 H10
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Welding Current	DC+
Diffusible Hydrogen	< 10 ml/100g
Alloy Type	C Mn
Shielding Gas	C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas AWS			
As Welded	506 MPa	596 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas AWS		
As Welded	0 °C	55 J
As Welded	-20 °C	42 J

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
2.4 mm	250-550 A	28-38 V	3.0-8.5 m/min	3.5-9.5 kg/h