

OK Tubrod 15.24S

A 1% Ni basic cored wire for submerged arc welding giving good toughness down to -50 °C.

Specifications

Classifications	SFA/AWS A5.23 : F7P8-EC-G (10.61) SFA/AWS A5.23 : F8A6-EC-G (10.62) SFA/AWS A5.23 : F8A6-EC-G (10.71) EN ISO 14171-A : S 46 4 AB TZ (10.71) EN ISO 14171-A : S 46 5 FB T3Ni1 (10.62)
Approvals	ABS : 4YQ460M H5 (10.62) BV : 4Y46M H5 (10.62) CE : EN 13479 (10.62) CE : EN 13479 (10.71) DNV-GL : IV Y46M(H5) (10.62) UKCA : EN 13479 (10.71)

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

Diffusible Hydrogen	<5ml/100g
Alloy Type	Low alloy (1% Ni)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS OK Flux 10.62			
As Welded	510 MPa	610 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS OK Flux 10.62		
As Welded	-50 °C	106 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
with OK Flux 10.71			
0.08	1.95	0.5	0.65
with OK Flux 10.61			
0.08	1.5	0.3	0.65
with OK Flux 10.62			
0.08	1.61	0.24	0.65

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
2.4 mm	250-500 A	28-38 V	1.5-2.5 m/min	3.5-9.5 kg/h
3.0 mm	400-800 A	28-40 V	2.5-6.0 m/min	6.0-14.5 kg/h
4.0 mm	500-900 A	28-40 V	2.0-5.5 m/min	7.0-18.0 kg/h