

OK Tubrod 15.27S

A basic cored wire designed for the submerged arc welding of steels with a minimum yield strength of 690 MPa.

Specifications

Classifications	SFA/AWS A5.23 : F11A8-EC-G (OK Flux 10.62) EN ISO 26304-A : T 69 6 FB TZ H5 (OK Flux 10.62)
Approvals	ABS : 5YQ690M H5 CCS : 5Y69M CE : EN 13479 (10.62) CE : EN 13479 DNV-GL : V Y69M(H5) LR : 5Y69M H5 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 high strength steel

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
OK Flux 10.62			
As Welded	747 MPa	812 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
OK Flux 10.62		
As Welded	-60 °C	80 J
As Welded	-40 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
OK Flux 10.62				
0.07	1.90	0.40	2.44	0.32

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	300-700 A	28-38 V	2.5-5.5 m/min	6.0-12.5 kg/h
3.2 mm	350-750 A	28-38 V	2.5-5.0 m/min	5.5-13.5 kg/h
4.0 mm	450-900 A	28-40 V	2.0-5.5 m/min	7.0-18.0 kg/h