

OK Tubrod 14.04

A 2% Ni metal cored wire which gives good toughness down to -60 degrees C using M21 shielding gas. All-positional except vertical down.

Specifications

Classifications	SFA/AWS A5.28 : E70C-G EN ISO 17632-A : T 42 6 2Ni M M21 2 H5
Approvals	ABS : 3YSAH10 CE : EN 13479 DNV-GL : V YMS(H10) LR : 5Y40S H5 (M21) UKCA : EN 13479 VdTÜV : 04304

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	460 MPa	570 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-60 °C	78 J
As Welded	-20 °C	141 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.05	0.98	0.40	2.26

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