

OK Tubrod 15.15

A positional rutile cored wire for use with C1 or M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C SFA/AWS A5.20 : E71T-1M EN ISO 17632-A : T 46 2 P C1 1 H5 EN ISO 17632-A : T 46 2 P M21 2 H5
Approvals	ABS : 3YSA H5 (M21,C1) BV : 3YS H5 (C1) BV : 3YS H5 (M21) CE : EN 13479 DB : 42.039.14 DNV : III YMS(H5) LR : 3YS H5 (M21,C1) NAKS/HAKC : 1.2mm UKCA : EN 13479 VdTÜV : 04175

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

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g (<10 ml/100g for 1.6mm)
Alloy Type	C Mn
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 AWS			
PWHT 3 hour(s) 620 °C	523 MPa	601 MPa	25.4 %
C1 EN			
As Welded	497 MPa	588 MPa	27 %
M21 EN			
As Welded	590 MPa	661 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 AWS		
PWHT	-20 °C	166 J
C1 EN		
As Welded	-20 °C	110 J
M21 EN		
As Welded	-30 °C	90 J
As Welded	-20 °C	120 J

Typical Weld Metal Analysis %

C	Mn	Si
M21 shielding gas		
0.06	1.40	0.40
C1 shielding gas		
0.05	1.31	0.31

MILD STEEL

GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)



OK Tubrod 15.15

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	20-30 V	3.2-14.5 m/min	1.3-5.8 kg/h
1.6 mm	150-360 A	24-34 V	3.0-11.0 m/min	2.0-6.2 kg/h