

OK Tubrod 15.13 C

A multi-purpose all positional rutile cored wire for use with C1 shielding gas.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1CJ H4 EN ISO 17632-A : T 46 4 P C1 1 H5
Approvals	ABS : 4YSA H5 (C1 & M21) BV : S4YM H5 (C1) DNV : IV Y40MS (H5) (C1) GL : 4YH5S (C1) LR : 3YS H5 (C1)

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

Welding Current	DC+
Alloy Type	C Mn

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 (EN ISO 14175)			
As Welded	529 MPa	586 MPa	25.5 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 (EN ISO 14175)		
As Welded	-40 °C	111 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
C1 (EN ISO 14175)			
0.056	1.39	0.43	0.40

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	27-35 V	5.6-19.8 m/min	2.1-7.5 kg/h