

OK Tubrod 15.22

A basic cored wire for welding 2.25%Cr 1% Mo creep resisiting steels using M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E90T5-B3
Welding Current	DC-
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Creep resisiting low alloy steel (2% Cr, 1% Mo)
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS M21 shielding gas			
PWHT 675DegC 1h 1 hour(s)	605 MPa	685 MPa	22 %

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
M21 shielding gas				
0.06	0.95	0.52	2.32	0.99

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	120-300 A	16-32 V	4.0-15.0 m/min	1.7-6.5 kg/h