

OK Tubrod 14.01

A 0.5% Cu metal cored wire for use with M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.18 : E70C-GM EN ISO 17632-A : T 42 2 Z M M21 2 H5
Approvals	CE : EN 13479 UKCA : EN 13479

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

Welding Current	DC+-
Diffusible Hydrogen	<4 ml/100g
Alloy Type	Low alloy (0.5% Cu).
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	489 MPa	595 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-20 °C	98 J

Typical Weld Metal Analysis %

C	Mn	Si	Cu
M21 shielding gas			
0.07	1.35	0.58	0.53

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