

OK Tubrod 15.07

An all-positional rutile wire for welding high strength steels such as Weldox 600 and X80 for transmission pipelines. The arc is stable over a wide parameter envelope, producing spatter-free welds with excellent slag release using Ar/20% CO₂ shielding gas. Root runs in joints are easily performed using ceramic backing and a minimum of post-weld grinding is required. The minimum preheating temperature is 80°C and the maximum interpass temperature is 150°C.

Specifications

Classifications

EN 12535 : T 62 4 Mn 2.5Ni P M 2 H5
SFA/AWS A5.29 : E101T1-K7M H4

Welding Current

DC+

Alloy Type

Low alloy

Typical Tensile Properties

Yield Strength

Tensile Strength

Elongation

M21 shielding gas

Typical Charpy V-Notch Properties

Condition

Testing Temperature

M21 shielding gas

As Welded

-50 °C

As Welded

-40 °C

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