

OK Tubrod 15.11

An all-positional rutile cored wire with good toughness down to -60 °C for the use with M21 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

Specifications	
Classifications	SFA/AWS A5.29 : E81T1-Ni2M EN ISO 17632-A : T 50 6 2Ni P M21 2 H5
Approvals	CE : EN 13479 DNV-GL : IV Y46MS H5 (M21) LR : 4Y46S H5 (M21) UKCA : EN 13479

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

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Low alloy (2.5% Ni)
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding gas			
As Welded	576 MPa	606 MPa	24 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
M21 Shielding gas		
As Welded	-60 °C	92 J

Typical Weld Metal Analysis %			
C	Mn	Si	Ni
M21 shielding gas			
0.04	0.86	0.32	2.20

Deposition Data				
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	110-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h