

OK Tubrod 15.20

A basic cored wire for welding 1%Cr 0.5% Mo creep resisting steels using M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E81T5-B2M H4
Welding Current	DC-
Diffusible Hydrogen	< 4 ml/100g
Alloy Type	Creep resisting low alloy steel (1% Cr, 0.5% Mo)
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
PWHT 1 hour(s) 690 °C	570 MPa	670 MPa	22 %

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
M21 shielding gas				
0.05	1.02	0.53	1.35	0.60

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