

## OK Tubrod 15.17

An positional rutile cored wire for use with M21 or C1 gas, providing very good toughness down to -40°C. The 1.2mm diameter is all-positional except vertical down.

| Specifications  |                                                                                                                                                                                                                                                       |
|-----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Classifications | SFA/AWS A5.29 : E81T1-Ni1MJ<br>SFA/AWS A5.29 : E81T1-Ni1CJ H4<br>EN ISO 17632-A : T 46 3 1Ni P C1 2 H5<br>EN ISO 17632-A : T 46 4 1Ni P M21 2 H5                                                                                                      |
| Approvals       | ABS : 3YSA H5 (C1)<br>ABS : 3YSA H5 (M21)<br>BV : SA3YM (M21)<br>BV : SA3YM HH (C1)<br>CE : EN 13479<br>DB : 42.039.26<br>DNV : IV Y46MS(H5)<br>LR : 3YS H5 (C1)<br>LR : 4Y46S H5 (M21)<br>RINA : 4Y46 S H5 (M21)<br>UKCA : EN 13479<br>VdTÜV : 05198 |

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

|                     |                                            |
|---------------------|--------------------------------------------|
| Welding Current     | DC+                                        |
| Diffusible Hydrogen | < 5 ml/100g (M21 gas) < 4 ml/100g (C1 gas) |
| Alloy Type          | Low alloy steel (1% Ni)                    |
| Shielding Gas       | M21, C1 (EN ISO 14175)                     |

| Tensile Properties |                |                  |            |
|--------------------|----------------|------------------|------------|
| Testing Condition  | Yield Strength | Tensile Strength | Elongation |
| M21 EN             |                |                  |            |
| As Welded          | 544 MPa        | 613 MPa          | 26 %       |

| Charpy Testing    |              |              |
|-------------------|--------------|--------------|
| Testing Condition | Testing Temp | Impact Value |
| M21 EN            |              |              |
| As Welded         | -40 °C       | 124 J        |

| Typical Weld Metal Analysis % |      |      |      |
|-------------------------------|------|------|------|
| C                             | Mn   | Si   | Ni   |
| M21 shielding gas             |      |      |      |
| 0.05                          | 1.15 | 0.34 | 0.96 |

| 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    |
| 1.6 mm          | 150-360 A | 24-34 V | 3.0-11.0 m/min  | 2.0-6.2 kg/h    |