

OK Tubrod 15.14 FCAW

Type Rutile E71T-1, E71T-1M

Description

OK Tubrod 15.14 is a flux-cored, tubular wire for all-positional welding using either Ar/CO₂ or CO₂. The wire is suitable for all mild and medium tensile structural steels. The running characteristics are exceptional, using the spray mode of transfer, and this applies equally to both shielding gases. OK Tubrod 15.14 is also universally approved to grade 3 by all major authorities. Shielding gas Ar/20%CO₂ or CO₂.

Welding current

DC+



Classifications

| | |
|---------------|---------------------------------------|
| SFA/AWS A5.20 | E71T-1, E71T-1M |
| EN 758:1997 | T 46 2 P M 2 H10, T 46 2 P C 2 H10 |

Typical all weld metal composition, %

| C | Si | Mn |
|------|-----|-----|
| 0.05 | 0.5 | 1.3 |

Typical mech. properties all weld metal

| | |
|-----------------------|-----|
| Yield stress, MPa | 530 |
| Tensile strength, MPa | 580 |
| Elongation, % | 26 |

Charpy V

| | |
|----------------|------------------|
| Test temps, °C | Impact values, J |
| -20 | 120 |

Approvals

| | | |
|------------|-----------------------|---|
| ABS | 3SA 3YSA | Ar/20%CO ₂ & CO ₂ |
| BV | SA3YM | Ar/20%CO ₂ & CO ₂ |
| DB | 42.039.05 | Ar/20%CO ₂ & CO ₂ |
| DNV | IIIYMS | Ar/20%CO ₂ & CO ₂ |
| DS | T 46 2 P M 2 H10 | Ar/20%CO ₂ |
| DS | T 46 2 P C 2 H10 | CO ₂ |
| GL | 3YS | Ar/20%CO ₂ & CO ₂ |
| LR | 3S 3YS | Ar/20%CO ₂ & CO ₂ |
| MoD (Navy) | MS<25mm, B&BX<12mm | Ar/20%CO ₂ & CO ₂ |
| RINA | 3Y S | Ar/20%CO ₂ |
| RINA | 2Y S | CO ₂ |
| RS | 3S 3YS | Ar/20%CO ₂ & CO ₂ |
| VdTÜV | 07651 | Ar/20%CO ₂ & CO ₂ |

Welding parameters

| Diameter, mm | Welding current, A | Arc voltage, V |
|--------------|--------------------|----------------|
| 1.2 | 110-300 | 21-32 |
| 1.4 | 130-320 | 22-32 |
| 1.6 | 150-360 | 24-34 |

This document was created with Win2PDF available at <http://www.win2pdf.com>.
The unregistered version of Win2PDF is for evaluation or non-commercial use only.
This page will not be added after purchasing Win2PDF.