

OK Tubrod 14.01 FCAW

Type Metal-cored

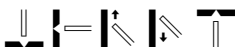
E70C-GM

Description

OK Tubrod 14.01 is a metal-cored wire containing copper, specially designed for the welding of Corten A & B and similar weathering steels or other high tensile structural steels with a tensile strength of up to 510 MPa. Shielding gas Ar + 20% CO₂. Slag levels are comparable with solid wire, often permitting multi-pass welding without inter-pass deslagging. OK Tubrod 14.01 is designed for bridge and general structural steelwork, ships and chimneys.

Welding current

DC+/-



Classifications

SFA/AWS A5.18	E70C-GM
EN 758	T 42 2 Z M M 2 H10

Typical all weld metal composition, %

C	Si	Mn	Cu
0.07	0.6	1.3	0.5

Typical mech. properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	550
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
0	130
-20	47

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	100-320	16-32