

# OK Tubrod 15.00 FCAW

Type Basic

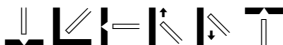
E71T-5, E71T-5M

## Description

OK Tubrod 15.00 is a flux-cored wire which deposits very low-hydrogen quality weld metal. Diameters 1.0 and 1.2 mm are available for positional welding. The slag cover is thin and easily remelted. Shielding gas CO<sub>2</sub> or Ar + 20% CO<sub>2</sub>. OK Tubrod 15.00 is designed for general fabrication where the risk of hydrogen-induced cracking is to be avoided.

## Welding current

DC-



## Classifications

SFA/AWS A5.20	E71T-5, E71T-5M
EN 758	T 42 3 B M 2 H5, T 42 3 B C 2 H5

## Typical all weld metal composition, %

C	Si	Mn
0.06	0.6	1.4

## Typical mech. properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	550
Elongation, %	30

## Charpy V

Test temps, °C	Impact values, J
-20	135
-30	120

## Approvals

CL	0485	Ar/20%CO <sub>2</sub>
DB	42.039.12	Ar/20%CO <sub>2</sub> & CO <sub>2</sub>
DNV	IIIYMS	Ar/20%CO <sub>2</sub>
DS	T 42 2 B M 2 H5	Ar/20%CO <sub>2</sub>
GL	3YH10S	Ar/20%CO <sub>2</sub>
LR	3S 3YS H15	Ar/20%CO <sub>2</sub>
RINA	3Y S H5	Ar/20%CO <sub>2</sub>
RINA	3Y S	CO <sub>2</sub>
VdTÜV	02181	Ar/20%CO <sub>2</sub> & CO <sub>2</sub>

## Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.0	100-230	14-30
1.2	120-300	16-32
1.4	130-350	16-32
1.6	140-400	24-34
2.0	200-450	24-34
2.4	300-500	26-36