

# OK Tubrod 15.15 FCAW

Type Rutile

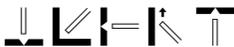
E71T-1, E71T-1M

## Description

OK Tubrod 15.15 is a flux-cored, tubular wire designed as a truly all-positional, general-purpose wire for welding mild and medium tensile steels up to 510 MPa tensile strength. Using either Ar/CO<sub>2</sub> or CO<sub>2</sub> as the shielding gas, the 1.2 and 1.4 mm sizes can be used in the vertical position on spray transfer providing for maximum deposition and time savings. Weld pool control is easy both vertically up and downwards and slag removal is rapid. OK Tubrod 15.15 is designed for a wide range of applications especially where manipulation of the work is impractical.

## Welding current

DC+



## Classifications

SFA/AWS A5.20	E71T-1, E71T-1M
EN 758:1997	T 46 2 P M 2 H5, T 46 2 P C 2 H5

## Typical all weld metal composition, %

C	Si	Mn
0.05	0.3	1.3

## Typical mech. properties all weld metal

Yield stress, MPa	520
Tensile strength, MPa	580
Elongation, %	28

## Charpy V

Test temps, °C	Impact values, J
-20	140

## Approvals

ABS	3SA 3YSA	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
BV	SA3YM HH	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
CL	CDS 0390	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
DB	42.039.14	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
DNV	III YMS	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
DS	T 46 2 P M 2 H5	Ar/20CO <sub>2</sub>
DS	T 46 2 P C 2 H5	CO <sub>2</sub>
GL	3YH10S	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
LR	3S 3YS H15	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
MoD (Navy)	MS<25mm	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
MRS	3YMSHH	Ar/20CO <sub>2</sub> & CO <sub>2</sub>
VdTÜV	04314	Ar/20CO <sub>2</sub> & CO <sub>2</sub>

## 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