

OK Tubrod 15.19 FCAW

Type Rutile

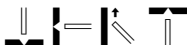
E81T1-Ni1M

Description

OK Tubrod 15.19 is an all-positional, rutile, flux-cored wire specially developed to produce high yield strength (min 550 MPa) and good toughness down to -50°C and high deposition spray transfer welding. Also suitable for open butt joints using non-fusible (e.g. ceramic) backing material. Shielding gas Ar + 20% CO₂. Ideal for welding quenched and tempered steels of the HY80 type.

Welding current

DC+



Classifications

SFA/AWS A5.29 E81T1-Ni1M

Typical all weld metal composition, %

C	Si	Mn	Ni
0.05	0.4	1.2	1.0

Typical mech. properties all weld metal

Yield stress, MPa	620
Tensile strength, MPa	650
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
-50	95

Approvals

MoD Navy Q1(N) Ar/20%CO₂&Ar/5%

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	110-300	21-32