

OK Tubrod 15.27 FCAW

Type Basic

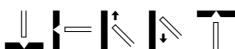
E110T5-G

Description

OK Tubrod 15.27 is a fully basic, flux-cored, tubular wire for the welding of high tensile strength steels such as HY100. The weld metal contains 2.5Ni, producing the additional benefit of low-temperature toughness down to -50°C. This wire is capable of welding in all positions and uses the dip transfer mode for the vertical-up technique, which can be further enhanced by the synergic pulsed process. Shielding gas Ar+20% CO₂.

Welding current

DC-



Classifications

SFA/AWS A5.28 E110T5-G

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.5	1.6	2.5

Typical mech. properties all weld metal

Yield stress, MPa	750
Tensile strength, MPa	820
Elongation, %	21

Charpy V

Test temps, °C	Impact values, J
-40	>50
-50	80

Approvals

MoD Q2N 95%Ar/5%CO₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	120-300	16-32