

# OK Tubrod 15.34

FCAW

Type Metal-cored

T 18 8 Mn M M 2

## Description

AISI 307 type metal-cored wire with a hot cracking-resistant austenitic weld metal, for welding armour steel, austenitic-manganese steel and dissimilar steels. Designed for the high deposition welding of (multi-layer) standing fillet welds. Shielding gas M13 (Ar/2%O<sub>2</sub>)

## Welding current

DC+



## Classifications

EN 12073

T 18 8 Mn M M 2

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni
0.1	0.7	6.3	18.5	8.0

## Typical mech. properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	635
Elongation, %	39

## Charpy V

Test temps, °C	Impact values, J
-60	45

## Approvals

DB	43.039.03
Ü	43.039/2
VdTÜV	04404

## Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	150-350	18-34