

OK Tubrod 15.00S SAW

Type Basic

F7A4-EC1

Description

OK Tubrod 15.00S is a tubular wire for submerged arc welding in conjunction with OK Flux 10.71, when high integrity welded joints are required in mild and medium tensile steels. General fabrication, structural engineering and shipbuilding are the principal areas of application. The welding of primed plate at high speeds is a particular benefit.

Welding current

DC+



Classifications

SFA/AWS A5.17 F7A4-EC1
EN 756 S 42 4 AB T3

Typical all weld metal composition, %

C	Si	Mn
0.07	0.5	1.5

Typical mech. properties all weld metal

Yield stress, MPa 430
Tensile strength, MPa 540
Elongation, % 30

Charpy V

Test temps, °C Impact values, J
-40 130

Approvals

ABS 3M 3YM
BV A3YM
CL CDS 1339
DB 52.039.14
DNV III YM
GL 3YM
LR 3M 3YM
VdTUV 09144
UDT approved

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
2.4	250-500	28-38
3.0	400-900	28-36
4.0	500-1000	28-34