

# OK Tubrod 15.24 FCAW

Type Basic

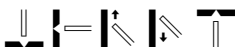
E80T5-G

## Description

OK Tubrod 15.24 is a fully basic, flux-cored wire depositing a 1Ni weld metal. It combines high strength with low-temperature toughness for service down to -50°C and has good CTOD performance. This applies to both the as-welded and stress-relieved condition. Good operability and slag release. Shielding gas Ar+20% CO<sub>2</sub> or CO<sub>2</sub>.

## Welding current

DC-



## Classifications

SFA/AWS A5.29 E80T5-G  
EN 758 T 46 5 Z B M 2 H5

## Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.5	1.5	0.7

## Typical mech. properties all weld metal

Yield stress, MPa 540  
Tensile strength, MPa 600  
Elongation, % 28

## Charpy V

Test temps, °C -50  
Impact values, J 120

## Welding parameters

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