OK Tubrod 15.15

A positional rutile cored wire for use with C1 or M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.20 : E71T-1C SFA/AWS A5.20 : E71T-1M EN ISO 17632-A : T 46 2 P C1 1 H5 EN ISO 17632-A : T 46 2 P M21 2 H5
Approvals	ABS : 3YSA H5 (M21,C1) BV : 3YS H5 (C1) BV : 3YS H5 (M21) CE : EN 13479 DB : 42.039.14 DNV : III YMS(H5) LR : 3YS H5 (M21,C1) NAKS/HAKC : 1.2mm UKCA : EN 13479 VdTÜV : 04175

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g (<10 ml/100g for 1.6mm)
Alloy Type	C Mn

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
C1 shielding gas AWS			
PWHT 3 hour(s) 620 °C	523 MPa	601 MPa	25.4 %
C1 shielding gas EN			
As Welded	528 MPa	560 MPa	27 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
C1 shielding gas AWS		
PWHT	-20 °C	166 J
C1 shielding gas EN		
As Welded	-20 °C	159 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
M21 shielding gas		
0.06	1.40	0.40
C1 shielding gas		
0.06	1.40	0.40

Deposition Data				
Diameter	**Amps**	**Volts**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	100-300 A	20-30 V	3.2-14.5 mm/min	1.3-5.8 kg/h
1.6 mm	150-360 A	24-34 V	3.0-11.0 mm/min	2.0-6.2 kg/h

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