

# OK Tubrod 15.00S

A basic cored wire for submerged arc welding.

<b>Classifications Weld Metal</b>	SFA/AWS A5.17 : F7A5-EC1 (OK Flux 10.62) SFA/AWS A5.17 : F7A4-EC1 (OK Flux 10.71) EN ISO 14171-A : S 42 4 AB T3 (OK Flux 10.71)
<b>Approvals</b>	ABS 3YM BV A3YM CE EN 13479 (10.71) CE EN 13479 DB 52.039.14 DNV III YM GL 3YM LR 3Ym PRS 3YM (10.71) VdTUV 09144

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+, AC
<b>Diffusible Hydrogen</b>	<5ml/100g
<b>Alloy Type</b>	C Mn

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>OK Flux 10.62</b>			
As Welded	465 MPa	540 MPa	26 %
<b>OK Flux 10.71</b>			
As Welded	463 MPa	556 MPa	29 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>OK Flux 10.62</b>		
As Welded	-40 °C	140 J
As Welded	-60 °C	75 J
<b>OK Flux 10.71</b>		
As Welded	-40 °C	114 J

## Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.07	1.61	0.59	0.010	0.015

## Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
2.4 mm	250-350 A	28-38 V	1.5-2.5 m/min	3.5-9.5 kg/h
3.0 mm	400-800 A	28-40 V	2.5-6.0 m/min	6.0-14.5 kg/h
4.0 mm	500-900 A	28-40 V	2.0-5.5 m/min	7.0-18.0 kg/h