OK Tubrod 15.13

A multi-purpose all positional rutile cored wire for use with C1 or M21 shielding gas.

Classifications Weld Metal	SFA/AWS A5.20 : E71T-1M H8 SFA/AWS A5.20 : E71T-1C H4 EN ISO 17632-A : T 42 3 P C1 1 H5 EN ISO 17632-A : T 46 4 P M21 1 H5
Approvals	ABS 3SA 3YSA H5 (C1 & M21) BV SA3M SA3YM H5 (M21) BV SA3M SA3YM HHH (C1) CE EN 13479 DB 42.039.21 DNV-GL III YMS(H5) (C1) LR 3YS H5 (C1 & M21) PRS 3YS H5 (C1 & M21) RINA 2YS H5 (C1) RINA 3YS H5 (M21) RINA 4YS H10 RS 3YH5 (C1 & M21) VdTUV 05019

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

Welding Current	DC+
Alloy Type	C Mn
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
As Welded	535 MPa	601 MPa	25 %
M21 shielding gas			
As Welded	550 MPa	620 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-30 °C	65 J
M21 Shielding gas		
As Welded	-40 °C	70 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.059	1.33	0.63	0.009	0.012

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	100-300 A	22-35 V	4.5-23.0 m/min	1.2-6.2 kg/h
1.2 mm	150-350 A	23-35 V	5.8-20.7 m/min	2.1-7.5 kg/h
1.4 mm	150-350 A	22-34 V	3.3-11.6 m/min	1.8-6.3 kg/h
1.6 mm	150-450 A	22-36 V	2.8-12.4 m/min	1.8-8.1 kg/h

410832-en_GB-FactSheet_Main-01 2022-05-27