

## OK Tubrod 15.14A

OK Tubrod 15.14A is a multipurpose all position flux cored wire for use with CO<sub>2</sub> or Ar/CO<sub>2</sub> shielding gas. The wire is suitable for all mild and medium tensile steels. The smooth metal transfer facilitates easy deposition even in positional welding. Weld metal is radiographically sound and provides good impact toughness down to -30°C.

<b>Classifications Weld Metal</b>	SFA/AWS A5.20 : E71T-1C/E71T-9C/E71T-1M/E71T-9M
<b>Approvals</b>	ABS 3YSA ABS 2SA (C1) ABS 3YSA H10 BV SA3YM H15 (C1) BV SA3YM HH CCS 3S 3YS H10 (C1) CE EN 13479 ClassNK KSW53G(C & M2) H10 CWB E491T-9-H8 (C1) CWB E491T-9-H8 / E491T-9M-H8 CWB E491T-9M-H16 (M21) DNV III YMS (C1 & M21) DNV-GL III YMS (H10) GL 3Y H10S (C1 & M21) GL 3Y H15S (C1) KR 3YSG(C)H10 LR 3YS H10 (C1 & M21) RS 3YS H10 (C1) VdTUV 06616

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

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	C-Mn

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>M21 shielding gas</b>			
<b>C1 shielding gas</b>			

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>M21 shielding gas</b>		
As Welded	-20 °C	90 J
As Welded	-30 °C	55 J
<b>C1 shielding gas</b>		
As Welded	-20 °C	84 J
As Welded	-30 °C	55 J

### Typical Weld Metal Analysis %

C	Mn	Si
0.04	1.30	0.50

### Current Range

Diameter	Current	Voltage
1.2 mm	140-330 A	22-34 V
1.4 mm	155-390 A	23-35 V
1.6 mm	170-460 A	24-36 V