

OK Tubrod 15.14A

OK Tubrod 15.14A is a multipurpose all position flux cored wire for use with CO₂ or Ar/CO₂ 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.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C/E71T-9C/E71T-1M/E71T-9M
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Approvals	ABS : 3YSA H10 BV : SA3YM (C1) BV : SA3YM HH CE : EN 13479 CWB : E491T1-C1A3-CS1-H8 CWB : E491T1-M21A3-CS1-H8 DNV-GL : III YMS LR : 3YS H10 (C1) UKCA : EN 13479 VdTÜV : 06616 ABS : 3Y400SA(H10) BV : SA3YM HH CCS : 3SH10, 3YSH10 (C1) ClassNK : KSW53G(C & M2) H10 KR : 3YSG(C)H10 LR : 3Y40S H10 (M21) LR : 3YS H10 (M21) RS : 3YS H10
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Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
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Alloy Type	C-Mn
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Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
M21 shielding gas				
As Welded	As welded	530 MPa	580 MPa	26 %
C1 shielding gas				
As Welded	As welded	490 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-20 °C	90 J
As Welded	-30 °C	55 J
C1 shielding gas		
As Welded	-20 °C	80 J
As Welded	-30 °C	50 J

Typical Weld Metal Analysis %

C	Mn	Si
0.04	1.30	0.50

Deposition Data

Diameter	Current	Voltage
1.2 mm	140-300 A	21-30 V

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Deposition Data

Diameter	Current	Voltage
1.6 mm	160-410 A	22-34 V

Recommended Welding Parameters

Current	Wire Diameter	Voltage	Wire Feed Speed
130-265 A	1.2 mm	22-29 V	3.8-13.2 m/min
135-355 A	1.4 mm	22-31 V	2.79-11.94 m/min
185-400 A	1.6 mm	24-32 V	2.79-10.67 m/min