OK Tubrod 15.17

An positional rutile cored wire for use with M21 or C1 gas, providing very good toughness down to -40°C. The 1.2mm diameter is all-positional except vertical down.

Specifications	
Classifications	SFA/AWS A5.29 : E81T1-Ni1MJ SFA/AWS A5.29 : E81T1-Ni1CJ H4 EN ISO 17632-A : T 46 3 1Ni P C1 2 H5 EN ISO 17632-A : T 46 4 1Ni P M21 2 H5
Approvals	ABS : 3YSA H5 (C1) ABS : 3YSA H5 (M21) BV : SA3YM (M21) BV : SA3YM HH (C1) CE : EN 13479 DB : 42.039.26 DNV : IV Y46MS(H5) LR : 3YS H5 (C1) LR : 4Y46S H5 (M21) RINA : 4Y46S H5 (M21) UKCA : EN 13479 VdTÜV : 05198

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

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g (M21 gas) < 4 ml/100g (C1 gas)
Alloy Type	Low alloy steel (1% Ni)
Shielding Gas	M21, C1 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 EN			
As Welded	544 MPa	613 MPa	26 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
M21 EN		
As Welded	-40 °C	124 J

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Ni**
M21 shielding gas			
0.05	1.15	0.34	0.96

Deposition Data				
Diameter	**Amps**	**Volts**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	110-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h
1.6 mm	150-360 A	24-34 V	3.0-11.0 m/min	2.0-6.2 kg/h