

OK Tubrod 14.04 FCAW

Type Metal-cored

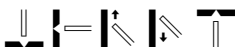
E70C-G

Description

OK Tubrod 14.04 contains nickel for applications that require -60°C impact properties, e.g. off-shore. Shielding gas Ar + 20% CO₂. The 1.2 mm and 1.4 mm diameter wires are suitable for all-positional welding using the dip transfer mode. OK Tubrod 14.04 is designed for all general fabrication and structural steelwork.

Welding current

DC-



Classifications

SFA/AWS A5.28	E70C-G
EN 758	T 42 6 2Ni M M 2 H10

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.4	1.0	2.3

Typical mech. properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	580
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-60	>47

Approvals

ABS	3SA, 3YSA	Ar/20 CO ₂
DNV	5YMS (H10) NV2-4,	Ar/20 CO ₂
	NV4-4	
DS	T 42 6 2Ni M M 2 H10	Ar/20 CO ₂
LR	5Y40S H15	Ar/20 CO ₂
RS	5YMSHH	Ar/20 CO ₂
VdTÜV		Ar/20 CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	100-320	16-32
1.4	120-380	16-34