

OK Tubrod 14.05 FCAW

Type Metal-cored

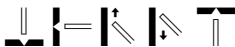
E70C-G

Description

OK Tubrod 14.05 is a metal-cored wire containing 1% nickel for toughness properties down to -40°C. Available in a wide range of sizes including 1.0 mm, which is ideal for root passes when used for one-sided welding. Shielding gas Ar + 20% CO₂. Slag levels are comparable with solid wire, often permitting multi-pass welding without inter-pass deslagging. OK Tubrod 14.05 is designed for all general fabrication and structural steel work, including offshore equipment where sub-zero impact properties are of prime importance.

Welding current

DC+/-



Classifications

SFA/AWS A5.28 E70C-G
EN 758 T 42 4 Z M M 2 H10

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.5	1.3	0.9

Typical mech. properties all weld metal

Yield stress, MPa >460
Tensile strength, MPa 550
Elongation, % >26

Charpy V

Test temps, °C Impact values, J
-20 >54
-40 >47

Approvals

ABS	3SA 3YSA	Ar/20%CO ₂
BV	SA3YM HH KV-40	Ar/20%CO ₂
DNV	IIIYMS H10	Ar/20%CO ₂
DS	T 42 4 Z M M 2 H10	Ar/20%CO ₂
LR	4Y40S H15	Ar/20%CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	100-320	16-32