

# OK Tubrod 15.09 FCAW

Type Rutile

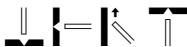
T 69 4 Z P M 2 H5

## Description

An all-positional rutile cored wire for welding high strength steel with a minimum yield strength of 690 MPa for use with M21 shielding gas. Diameters of less than 1.4 mm are all positional, with the exception of vertical down.

## Welding current

DC+



## Classifications

EN 12535-00

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## Typical all weld metal composition, %

C	Si	Mn	Ni	Mo
0.07	0.4	1.2	2.8	0.2

## Typical mech. properties all weld metal

Yield stress, MPa	780
Tensile strength, MPa	840
Elongation, %	19

## Charpy V

Test temps, °C	Impact values, J
-40	70

## Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	150-350	27-35