

OK Tubrod 15.17 FCAW

Type Rutile

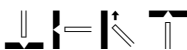
E81T1-Ni1M

Description

OK Tubrod 15.17 is an all-positional, rutile, flux-cored wire for good toughness down to -40°C. The wire contains 1% nickel and has exceptional operating characteristics in all positions with high deposition rates. Shielding gas Ar + 20% CO₂ or CO₂. OK Tubrod 15.17 is designed for the all-positional welding of carbon-manganese and low-alloy steels, e.g. offshore fabrications, vessels and structural steelwork.

Welding current

DC+



Classifications

SFA/AWS A5.29	E81T1-Ni1M
EN 758	T 46 3 1Ni P C 2 H5
	T 46 4 1Ni P M 2 H5

Typical all weld metal composition, %

C	Si	Mn	Ni
0.06	0.3	1.1	0.9

Typical mech. properties all weld metal

Yield stress, MPa	560
Tensile strength, MPa	600
Elongation, %	25

Charpy V

Test temps, °C	Impact values, J
-40	130

Approvals

ABS	3SA, 3YSA	Ar/20%CO ₂ &CO ₂
BV	SA3YM	Ar/20%CO ₂
BV	SA3YM HH KV -40	CO ₂
DB	42.039.26	Ar/20%CO ₂ &CO ₂
DNV	IVY42MS H10	Ar/20%CO ₂
DS	T 46 4 1Ni P M 2 H5	Ar/20%CO ₂
LR	3S, 4Y40S, H15	Ar/20%CO ₂
LR	3S, 3YS, H15	CO ₂
MoD (Navy)	MS>25mm, B&BX >12mm	Ar/20%CO ₂ &CO ₂
RS	4YMSH	Ar/20%CO ₂
VdTÜV		Ar/20%CO ₂ &CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	110-300	21-32
1.6	150-360	24-34