

OK Tubrod 14.00S SAW

Type Metal-cored

F7A2-EC1

Description

OK Tubrod 14.00S is a tubular wire designed for the submerged arc welding of mild and medium tensile steels and is suitable for fillet and multi-pass butt joints. When used in conjunction with OK Flux 10.71, exceptional productivity can be obtained at deposition rates up to 20% higher than with the same size of solid wire at the same current.

Welding current

DC+



Classifications

SFA/AWS A5.17 F7A2-EC1
EN 756 S 42 2 AB T 3

Typical all weld metal composition, %

C	Si	Mn
0.06	0.5	1.5

Typical mech. properties all weld metal

Yield stress, MPa 450
Tensile strength, MPa 530
Elongation, % 30

Charpy V

Test temps, °C Impact values, J
-20 120

Approvals

ABS 3M 3YM
BV A3YM
DB 52.039.13
DNV III YM
GL 3YM
LR 3M 3YM
VdTUV 9143
UDT approved

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
2.4	250-450	28-38
3.0	400-700	28-40
4.0	500-850	28-40