

OK Tubrod 14.02 FCAW

Type Metal-cored

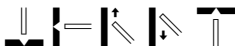
E80C-G

Description

OK Tubrod 14.02 is a metal-cored wire similar to OK Tubrod 14.12 with the addition of Mo for use on high tensile and quenched and tempered steels with tensile strengths of up to 550 MPa. Shielding gas Ar + 20% CO₂. Slag levels are comparable with solid wire, often permitting multi-pass welding without inter-pass deslagging. Suitable for marine structures, heavy machinery and high strength applications requiring good notch ductility. Steels include RQT 500, 600, Hyplus29, Ducol W30 and OK602.

Welding current

DC+/-



Classifications

SFA/AWS A5.28 E80C-G
EN 758 T 50 2 Z M M 2 H10

Typical all weld metal composition, %

C	Si	Mn	Mo
0.07	0.6	1.3	0.5

Typical mech. properties all weld metal

Yield stress, MPa 580
Tensile strength, MPa 650
Elongation, % 26

Charpy V

Test temps, °C Impact values, J
-20 65

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	100-320	16-32
1.6	140-450	18-36