

OK Tubrod 15.11

A rutile, all-positional, flux-cored, tubular wire containing 2.5 Ni for the welding of mild and medium tensile steels where good notch toughness down to -50°C is required. Extra productivity is available using the spray transfer mode when compared with the traditional basic types using short arc for vertical and overhead welding. All types of fabrication application involving mild and medium tensile steels with a min. yield strength of 510 MPa. This includes shipbuilding and offshore fabrication. Shielding gas: Ar + 20% CO₂.

Classifications Weld Metal	SFA/AWS A5.36: E81T1-M21-A8-Ni2 EN ISO 17632-A: T 50 6 2Ni P M21 2 H5
Approvals	CE EN 13479 DNV-GL IV Y46MS H5 (M21) LR 4Y46S H5 (M21)

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Low alloy (2.5% Ni)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding gas			
As Welded	576 MPa	606 MPa	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Condition
M21 Shielding gas		
As Welded	-60 °C	92 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 Shielding gas			
0.04	0.86	0.32	2.20

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	110-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h