

OK Tubrod 14.13 FCAW

Type Metal-cored

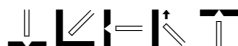
E70C-6M

Description

OK Tubrod 14.13 is a tubular wire particularly suited to the rapid welding of fillet and butt joints in the flat and horizontal positions. The arc action is stable at all current levels, which results in an excellent weld appearance with the absence of undercut and spatter.

Welding current

DC+



Classifications

SFA/AWS A5.18
EN 758

E70C-6M
T 42 2 M M 2 H5

Typical all weld metal composition, %

C	Si	Mn
0.06	0.5	1.4

Typical mech. properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	580
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	90

Approvals

ABS	3SA 3YSA	Ar/20 CO ₂
BV	SA3YM	Ar/20 CO ₂
DB	42.039.03	Ar/20 CO ₂
DNV	IIIYMS	Ar/20 CO ₂
DS	T 42 2 M M 2 H10	Ar/20 CO ₂
GL	3YS	Ar/20 CO ₂
LR	3S 3YS	Ar/20 CO ₂
VdTÜV	09086	Ar/20 CO ₂
MoD(N)	MS<25mm, B&BX<12mm	Ar/20 CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	100-320	16-32
1.4	120-380	16-34
1.6	140-450	18-36