

OK Tubrod 14.12 FCAW

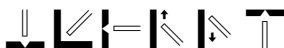
Type Metal-cored E70C-6M, E70C-6C

Description

OK Tubrod 14.12 is a tubular wire for use with both Ar/CO₂ mixtures or CO₂ shielding gases. Improved productivity and weld quality compared with solid wire under CO₂. It is especially suitable for fillet welding and has a high tolerance to primer.

Welding current

DC(+/-)



Classifications

SFA/AWS A5.18	E70C-6M, E70C-6C
EN 758	T 42 2 M M 1 H10, T 42 2 M C 1 H10

Typical all weld metal composition, %

C	Si	Mn
0.07	0.6	1.3

Typical mech. properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	550
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	100

Approvals

ABS	3SA, 2YSA	Ar/CO ₂ & CO ₂
BV	SA3YM	Ar/CO ₂ & CO ₂
DB	42.039.24	Ar/CO ₂ & CO ₂
DNV	IIIYMS	Ar/CO ₂ & CO ₂
DS	T 42 2 M M 1 H10	Ar/CO ₂ & CO ₂
DS	T 42 2 M C 1 H10	CO ₂
GL	3YS	Ar/CO ₂ & CO ₂
LR	3S, 3YS	Ar/CO ₂ & CO ₂
RINA	3Y S	Ar/CO ₂ & CO ₂
VdTUV	06649	Ar/CO ₂ & CO ₂

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.0	80-250	14-30
1.2	100-320	16-32
1.4	120-380	16-34
1.6	140-450	18-36