



# Product Data Sheet

S 'Submerged arc welding'

# OK Tubrod 14.00S

Prepared by Magnus Johansson	Qualified by Tero Tolonen	Approved by Neil Farrow	Reg no EN006417	Cancelling EN004936	Reg date 2014-06-10	Page 1 (2)
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## REASON FOR ISSUE

Classification standard updated

## GENERAL

A metal cored wire for submerged arc welding.

**Polarity:** DC+, AC

**Alloy Type:** C Mn

**Fill Type:** Metal cored

**Auxiliary:** OK Flux 10.71

**Diff Hydrogen:** < 10 ml/100g

## CLASSIFICATIONS Flux

EN ISO 14174 SA AB 1 67 AC H5

## CLASSIFICATIONS Weld Metal

SFA/AWS A5.17 F7A2-EC1

## APPROVALS

ABS	3YM (10.71)
BV	A3YM (10.71)
CE	EN 13479 (10.71)
DB	52.039.13 - 51.039.05 (10.71)
DNV	IIIYM (10.71)
GL	3YM (10.71)
LR	3YM (10.71)
VdTÜV	09143 (10.71)

## CHEMICAL COMPOSITION

### All Weld Metal (%)

with OK Flux 10.71

	Min	Max
C	0.03	0.08
Si	0.3	0.7
Mn	1.4	1.8
P		0.025
S		0.025
Cr		0.2
Ni		0.5
Mo		0.2
V		0.08
Nb		0.05
Cu		0.3

## MECHANICAL PROPERTIES OF WELD METAL

### All Weld Metal

EN  
with OK Flux 10.71

As welded

Properties	Min	Max	Typ
ReL (MPa)	420		454
Rm (MPa)	500	640	538
A5 (%)	22		30
at -20°C (J)	54		132



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## ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed			U Min	Max
	Min	Max			Min	Max	Min	Max	Min		
2.4	250	450		90-95	4.0	9.0	2.0	5.0	28		38
3.0	400	700		90-95	5.5	12.0	2.5	5.5	28		40
4.0	500	850		90-95	6.5	12.5	2.0	5.0	28		40

**W** = Gas consumption (l / min)

**η** = Recovery, g weld metal / 100g wire (%)

**H** = Deposit rate (kg weld metal / hour arc time)

**Feed** = Feeding rate (m/min)

**U** = Arc voltage (V)

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## OTHER DATA

The hydrogen values are determined according to the method given in ISO 3690.

Welding parameters for hydrogen determination: Wire diameter 4.0mm, OK Flux 10.71, 600 amps, 30 volts, 30mm stickout.

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