



Product Data Sheet

S 'Submerged arc welding'

OK Tubrod 15.00S

Prepared by Magnus Johansson	Qualified by Tero Tolonen	Approved by Neil Farrow	Reg no EN006416	Cancelling EN005317	Reg date 2014-06-10	Page 1 (2)
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REASON FOR ISSUE

Classification updated

GENERAL

A basic cored wire for submerged arc welding.

Alloy Type: C Mn

Fill Type: Basic

Diff Hydrogen: <5ml/100g

CLASSIFICATIONS Weld Metal

SFA/AWS A5.17	F7A4-EC1 (OK Flux 10.71)
SFA/AWS A5.17	F7A5-EC1 (OK Flux 10.62)
EN ISO 14171-A	S 38 4 AB TZ (OK Flux 10.47)
EN ISO 14171-A	S 42 4 AB T3 (OK Flux 10.71)

APPROVALS

ABS	3YM (10.71)
BV	A3YM (10.71)
CE	EN 13479 (10.71)
DB	52.039.14 - 51.039.05 (10.71)
DNV	IIIYM (10.71)
GL	3YM (10.71)
LR	3YM (10.71)
PRS	3YM (10.71)
VdTÜV	09144 (10.71)

CHEMICAL COMPOSITION

All Weld Metal (%)

	OK Flux 10.47		OK Flux 10.62		OK Flux 10.71	
	Min	Max	Min	Max	Min	Max
C	0.03	0.08	0.03	0.08	0.04	0.10
Si	0.30	0.70	0.30	0.70	0.30	0.70
Mn	1.10	1.60	1.10	1.60	1.35	1.80
P		0.025		0.025		0.025
S		0.025		0.025		0.025
Cr		0.2		0.2		0.2
Ni		0.5		0.5		0.5
Mo		0.2		0.2		0.2
V		0.08		0.08		0.08
Nb		0.05		0.05		0.05
Cu		0.3		0.3		0.30

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	OK Flux 10.47		OK Flux 10.62		Typ	OK Flux 10.71	
	Min	Max	Min	Max		Min	Max
As welded							
Rp0.2 (MPa)	400		400		465	420	
Rm (MPa)	510	640	510	640	540	510	640
A5 (%)	22		22		26	22	
at -40°C (J)	47		47		140	47	
at -60°C (J)					75		



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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	350		85	3.5	9.5	1.5	2.5	28		38
3.0	400	800		85	6.0	14.5	2.5	6.0	28		40
4.0	500	900		85	7.0	18.0	2.0	5.5	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)

OTHER DATA

The diffusible hydrogen values are determined in accordance with ISO 3690. Welding parameters for 4.0mm diameter wire: 600 amps, 31 volts, 30mm electrode extension with OK Flux 10.71.
