



Product Data Sheet

S 'Submerged arc welding'

OK Tubrodur 23Cr S

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REASON FOR ISSUE

Name changed from OK Tubrodur 15.91S

GENERAL

A cored wire for submerged arc welding which produces a 22%Cr 4%Ni 1%Mo weld metal used under flux in the submerged arc process.

CLASSIFICATIONS Weld Metal

EN 14700 T Fe7

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.025	0.055
Si		1.2
Mn		0.5
P		0.04
S		0.04
Cr	21.0	25.0
Ni	2.5	5.0
Mo	1.1	1.8

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U		
	\emptyset	Min			Max	Nom	Nom	Min	Max	Min	Max
	3.0	400	700		95	5.5	12.0	2.5	5.5	28	36

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)