



Product Data Sheet

OK Tubrodur 15CrMn O/G

T 'Tubular cored electrode arc welding'

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REASON FOR ISSUE

Name changed from OK Tubrodur 15.65

GENERAL

A cored wire which produces a work-hardening austenitic weld metal with high wear and impact resistance. Used with C1 shielding gas or self-shielded.

Shielding Gas: None, C1 (EN ISO 14175)

Alloy Type: 14% Mn 14%Cr steel weld metal

Polarity: DC+

Fill Type: Low slag rutile

CLASSIFICATIONS Weld Metal

APPROVALS

EN 14700 T Fe9

CE EN 13479

DB 82.039.10

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.25	0.35
Si	0.3	0.8
Mn	12.0	15.0
Cr	14.0	17.0
Ni	1.5	2.0
Mo	0.6	1.0
V	0.5	0.8

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
	Min	Max			Nom	Nom	Min	Max	Min	Max
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1.2	150	250		78	3.3	7.2	6.5	21.5	28	37
1.6	200	330		80	3.7	8.0	5.0	12.0	24	33

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)

Part Number	Description	MOQ	UOM	Pallet Qty.	UOM
1565167730	OK Tubrodur 15CrMn O/G 1.6mm 16kg Spool Vac Packed (TFE-9)	16	KG	896	KG