



Product Data Sheet

OK Tubrodur 13Mn O/G

T 'Tubular cored electrode arc welding'

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REASON FOR ISSUE

Name changed from OK Tubrodur 15.60

GENERAL

A self-shielded cored wire which may also be used with C1 shielding gas, intended for rebuilding 13% manganese steels.

Shielding Gas: None, C1 (EN ISO 14175)

Alloy Type: 13% manganese steel weld metal

Polarity: DC+

Fill Type: Slagforming, rutile

CLASSIFICATIONS Weld Metal

EN 14700 T Fe9

CHEMICAL COMPOSITION

All Weld Metal (%)

	No shielding gas	
	Min	Max
C	0.7	1.0
Si		1.0
Mn	11.5	13.5
P		0.03
S		0.03
Ni	2.5	3.5
Al	0.2	0.8

Comments:
Hardness = 200 - 250 Hv

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
	Min	Max			Nom	Nom	Min	Max	Min	Max
\emptyset 1.6	150	260		85	2.5	3.2	2.0	4.2	24	30

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)