

OK Tubrod 14.11

OK Tubrod 14.11 is a wire that has been specially designed for robotic applications, particularly in the area of thin plate welding. The welding characteristics of the wire permit the use of lower arc voltages in the spray transfer mode, which reduces arc power and thereby reduces the risk of blow-through in situations where the fit-up is variable. The wire also exhibits excellent feedability and deposits weld metal of the highest quality with Ar + 20% CO₂ shielding gas.

Classifications Weld Metal:	SFA/AWS A5.36:E70T15-M12A4-G-H4, SFA/AWS A5.36:E70T15-M21A4-G-H4, EN ISO 17632-A:T 42 4 M M 3 H5
Approvals:	CE EN 13479, BV S3YM H5 (M21), LR 4Y40SH5 (M21), ABS 4Y400SA H5 (M21), DB 42.039.28 (M21), DNV III Y40 H5 (M21), GL 4Y40H5S (M21), VdTÜV 10010

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Alloy Type:	C Mn

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21			
As welded	453 MPa	558 MPa	32 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21		
As welded	-40 °C	55 J

Typical Weld Metal Analysis %

C	Mn	Si
M12		
0.050	1.9	0.9
M21		
0.048	1.45	0.64

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-350 A	14-32 V	1.8-18.5 m/min	1.3-8.0 kg/h
1.4 mm	150-350 A	18-33 V	3.5-12.1 m/min	2.1-7.2 kg/h