OK Autrod 13.14

OK Autrod 13.14 is a copper coated low alloyed wire for GMAW of HSLA steels. It is used for fabrication of tractor cylinder, automobile components and wagons. The wire is designed to produce excellent beads of radiographic quality in all positions. One of the major applications of OK Autrod 13.14 is for welding 'CONCOR' wagons of the Indian Railways.

Classifications Wire Electrode:	SFA/AWS A5.28:ER90S-D2
Approvals:	RDSO Class III

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

Alloy Type:	Low Alloyed (0.5% Mo)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding gas			
As Welded	570 MPa	650 MPa	26 %
M21 Shielding gas			
As Welded	590 MPa	690 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding gas		
As Welded	-30 °C	45 J
M21 Shielding gas		
As Welded	-30 °C	60 J

Typical Wire Composition %

C	Mn	Si	Mo
0.11	2.00	0.60	0.42

Current Range

Diameter	Current	Voltage
1.2 mm	120-280 A	20-28 V
1.6 mm	225-360 A	26-34 V