OK Tigrod 12.64

A copper coated, G4Si1/ER70S-6 rod for GTAW of general structural and engineering unalloyed and low-alloyed carbon-manganese steels. Compared with OK Tigrod 12.61, OK Tigrod 12.64 has a slightly higher silicon and manganese content, which increases the weld metal strength. The high silicon content promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

Classifications	EN ISO 636-A : W 46 5 4Si1 EN ISO 636-A : W 4Si1 SFA/AWS A5.18 : ER70S-6
Approvals	ABS : 3Y (I1) BV : 3YM CE : EN 13479 DNV-GL : III YM (I1) LR : 3Ym H15 (I1) NAKS/HAKC : 1.6MM-2.4MM VdTÜV : 05260

Alloy Type	Carbon-manganese steel

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Ar (I1) AWS			
Stress Relieved 2 hour(s) 620 °C	400 MPa	525 MPa	32 %
As Welded	510 MPa	610 MPa	30 %
Ar (I1) EN			
As Welded	525 MPa	595 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Ar (I1) AWS		
Stress Relieved 2 hour(s) 620 °C	-46 °C	80 J
As Welded	-46 °C	100 J
Ar (I1) EN		
As Welded	-50 °C	90 J
As Welded	-40 °C	150 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P
Ar				
0.08	1.28	0.80	0.013	0.015

Typical Wire Composition %

C	Mn	Si
0.074	1.68	0.95

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