

OK Tigrod 13.12

A copper coated, low alloyed, chromium-molybdenum (1% Cr, 0.5% Mo) rod for GTAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers. The rod can also be used for welding low-alloyed high strength steels with a minimum tensile strength of 550 Mpa.

Classifications	EN ISO 21952-A : W CrMo1Si EN ISO 21952-B : W 55 I1 1CM3 SFA/AWS A5.28 : ER80S-G
Approvals	CE : EN 13479 NAKS/HAKC : 1.6-2.4 mm VdTÜV : 04952

Alloy Type	Low alloyed steel (1 % Cr - 0.5 % Mo)
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
Ar (I1) EN ISO			
Stress Relieved 1 hour(s) 700 °C	560 MPa	650 MPa	25 %
Ar (I1) AWS			
As Welded	560 MPa	720 MPa	24 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
Ar (I1) EN ISO		
Stress Relieved 1 hour(s) 700 °C	-40 °C	120 J
Stress Relieved 1 hour(s) 700 °C	20 °C	250 J
Ar (I1) AWS		
As Welded	-30 °C	40 J
As Welded	20 °C	120 J
As Welded	-20 °C	50 J
As Welded	-60 °C	20 J
As Welded	-40 °C	20 J

Typical Wire Composition %						
C	Mn	Si	S	P	Cr	Mo
0.09	1.00	0.65	0.010	0.015	1.18	0.49

Typical Weld Metal Analysis %						
C	Mn	Si	S	P	Cr	Mo
0.10	1.00	0.70	0.015	0.015	1.10	0.50