

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

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

Alloy Type	Low alloyed steel (1 % Cr - 0.5 % Mo)
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Ar (I1) AWS			
As Welded	560 MPa	720 MPa	24 %
Ar (I1) EN ISO			
Stress Relieved 1hr 700°C	560 MPa	650 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Ar (I1) AWS		
As Welded	20 °C	120 J
As Welded	-20 °C	50 J
As Welded	-30 °C	40 J
As Welded	-40 °C	20 J
As Welded	-60 °C	20 J
Ar (I1) EN ISO		
Stress Relieved 1hr 700°C	20 °C	250 J
Stress Relieved 1hr 700°C	-40 °C	120 J

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

Typical Wire Composition %

C	Mn	Si	S	P	Cr	Mo
0.09	1.00	0.65	0.010	0.015	1.18	0.49