OK Tigrod 13.08

A copper coated, low alloyed, manganese-molybdenum (1,5% Mn, 0,4% Mo) rod for GTAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers with a working temperature of up to about 500°C. The rod can also be used for welding low-alloyed high tensile strength steels.

Classifications Weld Metal	EN ISO 636-A : W 50 3 Z 2Mo EN ISO 636-B : W55A 3 4M31
Classifications Wire Electrode	SFA/AWS A5.28 : ER80S-D2 EN ISO 636-A : Z 2Mo EN ISO 636-B : 4M31
Approvals	NAKS/HAKC 2.4mm

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Ar (I1) AWS			
As Welded	520 MPa	615 MPa	28 %
Ar (I1) EN			
As Welded	620 MPa	690 MPa	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Ar (I1) AWS		
As Welded	-30 °C	80 J
Ar (I1) EN		
As Welded	-30 °C	110 J

Typical Wire Composition %

C	Mn	Si	Ni	Mo
0.07	1.8	0.7	0.05	0.4

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