

OK Tigrod 12.61

GTAW
ER70S-6

Description

OK Tigrod 12.61 is a copper-coated Mn-Si-alloyed W3Si1/ER70S-6 solid rod for the GTAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding.

Welding current

DC(-)

Classifications

SFA/AWS A5.18
EN 1668

ER70S-6
W3Si1

Wire composition

C	Si	Mn
0.1	0.9	1.5

Typical properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	560
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
-30	70

Approvals

DB	42.039.07
U	42.039/2
VdTÜV	09124

Packing data

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0
4.0	1000	5.0