

OK Tigrod 13.12

GTAW

ER80S-G

Description

OK Tigrod 13.12 is a 1.0Cr-0.5Mo-alloyed, copper-coated rod for the 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.

Welding current

DC(-)

Classifications

SFA/AWS A5.28	ER80S-G
DIN 8575	W.nr. 1.7339
EN 12070	W CrMo1Si

Wire composition

C	Si	Mn	Cr	Mo
0.1	0.6	1.0	1.2	0.5

Typical mech. properties all weld metal

Yield stress, MPa	560
Tensile strength, MPa	720
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
+20	120
-20	50
-30	40
-40	20
-60	20

Approvals

UDT	DIN 8575
VdTÜV	04952

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.0	1000	5.0
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