

## OK Tigrod 13.12

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.

<b>Classifications Wire Electrode:</b>	SFA/AWS A5.28:ER80S-G, EN ISO 21952-A:W CrMo1Si, EN ISO 21952-B:W 55 1CM3
<b>Approvals:</b>	NAKS/HAKC 2.4mm, VdTUV 04952

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

<b>Alloy Type:</b>	Low alloyed steel (1 % Cr - 0.5 % Mo)
--------------------	---------------------------------------

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>Ar (I1) AWS</b>			
As welded	560 MPa	720 MPa	24 %
<b>Ar (I1) EN</b>			
Stress relieved 0,5 hr 700 °C	560 MPa	650 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>Ar (I1) AWS</b>		
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
<b>Ar (I1) EN</b>		
Stress relieved 0,5 hr 700 °C	20 °C	180 J

Typical Wire Composition %					
C	Mn	Si	Ni	Cr	Mo
0.09	1.00	0.65	0.02	1.18	0.49