

## 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.

### Specifications

|                        |                                                                                                                                      |
|------------------------|--------------------------------------------------------------------------------------------------------------------------------------|
| <b>Classifications</b> | EN ISO 636-A : W 50 3 Z 2Mo<br>EN ISO 636-B : W55A 3 4M31<br>EN ISO 636-A : Z 2Mo<br>EN ISO 636-B : 4M31<br>SFA/AWS A5.28 : ER80S-D2 |
|------------------------|--------------------------------------------------------------------------------------------------------------------------------------|

|                      |                              |
|----------------------|------------------------------|
| <b>Alloy Type</b>    | Low alloyed steel (0.5 % Mo) |
| <b>Shielding Gas</b> | I1 (EN ISO 14175)            |

### Typical Tensile Properties

| Condition          | Yield Strength | Tensile Strength | Elongation |
|--------------------|----------------|------------------|------------|
| <b>Ar (I1) AWS</b> |                |                  |            |
| As Welded          | 520 MPa        | 615 MPa          | 28 %       |
| <b>Ar (I1) EN</b>  |                |                  |            |
| As Welded          | 620 MPa        | 690 MPa          | 24 %       |

### Typical Charpy V-Notch Properties

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

### Typical Wire Composition %

| C    | Mn  | Si  | Ni   | Mo  |
|------|-----|-----|------|-----|
| 0.07 | 1.8 | 0.7 | 0.05 | 0.4 |