

OK TIGROD 13.09

A Cu coated 0.5Mo alloyed solid rod for GTAW

Classification AWS A5.28: ER80S-G

DESCRIPTION

OK TIGROD 13.09 is copper coated 0.5Mo alloyed solid for the 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 high strength low alloy steels.

APPROVALS: CE, DB, DNV & VdTÜV

WELDING CURRENT: DC-

SHIELDING GAS: Ar

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm ²)	540
Si	0.60	UTS (N/mm ²)	630
Mn	1.10	Elongation (%)	25
Mo	0.50	Impact (CVN)	
Cu	0.15	@ -40°C (Joules)	90

PACKING DATA

Size (mm)	Length (mm)	Packing (5 Kg.)
1.6	1000	✓
2.0	1000	✓
2.4	1000	✓
3.2	1000	✓

PACKING: The rods are packed in tubes weighing 5 kg.