Product Data Sheet

OK Tigrod 12.60

Signed by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

A new specification

GENERAL

A copper coated, manganese-silicon alloyed rod for GTAW of all general engineering and structural steels with a minimum yield strength of max 380 MPa. The rod is usually welded with pure argon (I1) as the shielding gas.

Shielding Gas: I1 (EN 439)

Alloy Type: Carbon-manganese steel

CLASSIFICATIONS Weld Metal

EN 1668	W 38 3 W2Si

APPROVALS

Sepros	UNA 485178

CLASSIFICATIONS Wire Electrode

EN 1668	W2Si
SFA/AWS A5.18	ER70S-3

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Ar		
	Nom	**Min**	**Max**
C	0.10	0.06	0.14
Si	0.72	0.50	0.75
Mn	1.11	0.90	1.30
P	0.013		0.025
S	0.012		0.025

MECHANICAL PROPERTIES OF WELD METAL

	All Weld Metal			
	Ar (I1) EN			Ar (I1) AWS
	As welded			As welded
Properties	**Min**	**Max**	**Typ**	**Min**
ReL (MPa)	380		420	400
Rm (MPa)	470	600	515	480
A4-A5 (%)	22		26	22
Charpy V at -18°C (J)				27
Charpy V at -30°C (J)	47		90	

OTHER DATA

Length of rods: 1000 mm.

Dimensions available are: 1.6, 2.0, 2.4, 3.2 and 4.0 mm.

The wire rods are delivered in boxes of 5.0 kg net weight.