

OK Tigrod 16.95

GTAW
W 18 8 Mn

Description

Bare, corrosion-resistant, chromium-nickel-manganese welding rods for welding austenitic stainless alloys of the 18% Cr, 8% Ni, 7% Mn types. OK Tigrod 16.95 has general corrosion resistance similar to that of the corresponding parent metal. The higher silicon content improves the welding properties such as wetting. When used for joining dissimilar materials, the corrosion resistance is of secondary importance. The alloy is used in a wide range of applications across the industry, such as the joining of austenitic, manganese, work-hardenable steels, as well as armour plate and heat-resistant steels.

Welding current

DC(-)

Classifications

EN 12072	W 18 8 Mn
Werkstoffnummer	appr. 1.4370

Wire composition

C	Si	Mn	Cr	Ni
<0.2	<1.2	6.5	18.5	8.5

Typical mech. properties all weld metal

Yield stress, MPa	450
Tensile strength, MPa	640
Elongation, %	41

Charpy V

Test temps, °C	Impact values, J
+20	130

Approvals

DB	43.039.12
UDT	DIN 8556
Ü	43.039/1
VdTÜV	

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.2	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0