

OK Tigrod 13.13 GTAW

ER100S-G

Description

OK Tigrod 13.13 is a 0.5Cr-0.5Ni-0.2Mo-alloyed, copper-coated rod for the GTAW of high strength steels with a minimum tensile strength of 690 MPa. The rod is also suitable for welding steels where good impact strength at low temperatures is required.

Welding current

DC(-)

Classifications

SFA/AWS A5.28 ER100S-G
EN 12534 Mn3NiCrMo

Wire composition

C	Si	Mn	Cr	Ni	Mo
0.1	0.7	1.4	0.6	0.6	0.2

Typical mech. properties all weld metal

Yield stress, MPa 585
Tensile strength, MPa 750
Elongation, % 27

Charpy V

Test temps, °C	Impact values, J
0	150
-20	85
-40	69

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.0	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0
4.0	1000	5.0