

OK Tigrod 12.60

Features Specifications

OK Tigrod 12.60

GTAW

Type Carbon-manganese

OK Tigrod 12.60 is a copper-coated Mn-Si-alloyed W2Si/ER70S-3 solid rod for the GTAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding.

Welding current

DC(-)

Classifications	Approvals	Typical all weld metal composition, %	Typical mech. properties all weld metal
SFA/AWS A5.18 ER70S-3 EN ISO 636-A W2Si	Sepros UNA 485178	C 0,1 Si 0,6 Mn 1,1 Wire composition	<u>Yield stress, MPa</u> 420 <u>Tensile strength, MPa</u> 515 <u>Elongation, %</u> 26 <u>Elongation, %</u> 26 <u>Charpy V</u> Test temps, °C Impact values, J -30 90

Diameter, mm	1,6	2,0	2,4	3,2	4,0
Length, mm	1000	1000	1000	1000	1000
Weight of rods/box, kg	5,0	5,0	5,0	5,0	5,0

OK Tigrod 12.64

Features Specifications

OK Tigrod 12.64

GTAW

Type Carbon-manganese

OK Tigrod 12.64 is a copper-coated Mn-Si-alloyed W4Si1/ER70S-6 solid rod for the GTAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding. It has a slightly higher manganese and silicon content than OK Tigrod 12.61 to increase the weld metal strength. This also promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

Welding current

DC(-)

Classifications	Approvals		Typical all weld metal composition, %		Typical mech. properties all weld metal	
<u>SFA/AWS A5.18</u>	ABS	3, 3Y	C	0,09	<u>Yield stress, MPa</u> 525	
<u>ER70S-6</u>	DNV	III YM(II)	Si	1,0	<u>Tensile strength, MPa</u> 595	
<u>EN ISO 636-A</u>			Mn	1,7	<u>Elongation, %</u> 26	
<u>W4Si1</u>	GL	3Y	Wire composition		<u>Elongation, %</u> 26	
	LR	3 3Y			<u>Elongation, %</u> 26	
	VdTÜV	05260			<u>Charpy V</u>	
	CE	EN 13479			Test temps, Impact °C values, J -30 70	

Diameter, mm	1,6	2,0	2,4	3,2	4,0
Length, mm	1000	1000	1000	1000	1000
Weight of rods/box, kg	5,0	5,0	5,0	5,0	5,0