

OK Tigrod 16.95

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OK Tigrod 16.95

GTAW

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	Approvals		Typical all weld metal composition, %		Typical mech. properties all weld metal		
<u>EN ISO 14343</u> W 18 8 Mn <u>Werkstoffnummer</u> ~1.4370	DB	43.039.12	C	<0,2	<u>Yield stress, MPa</u> 450		
			VdTÜV	05421	Si	<1,2	<u>Tensile strength, MPa</u> 640
				Mn	6,5	<u>Elongation, %</u> 41	
				Cr	18,5	<u>Elongation, %</u> 41	
				Ni	8,5	<u>Charpy V</u>	
				Mo	<0,3		
				Cu	<0,3	Test temps, Impact °C values, J	
				Wire composition		+20	130

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

OK Tigrod 2209

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OK Tigrod 2209

GTAW

Bare, corrosion-resistant, duplex welding rods for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types. OK Tigrod 2209 has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has high resistance to intergranular corrosion, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.

Welding current

DC(-)

Classifications	Approvals		Typical all weld metal composition, %		Typical mech. properties all weld metal	
<u>EN ISO 14343</u> W 22 9 3 NL <u>SFA/AWS A5.9</u> ER2209	CL		C	<0,03	<u>Yield stress, MPa</u> 600	
	Sepros	UNA 485178	Si	0,5	<u>Tensile strength, MPa</u> 765	
			Mn	1,7	<u>Elongation, %</u> 28	
	UDT	DIN 8556	Cr	22,5	<u>Elongation, %</u> 28	
	VdTÜV 05519 (IT)		Ni	8,5	<u>Charpy V</u>	
			Mo	3,3		
	VdTÜV 06282 (FP)		Cu	<0,3	Test temps, °C	Impact values, J
		Wire composition		+20	100	
				-20	85	
				-60	60	

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

OK Tigrod 308L

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OK Tigrod 308L

GTAW

Bare, corrosion-resistant, chromium-nickel TIG rod. OK Tigrod 308L has good general corrosion resistance. The alloy has a low carbon content which makes it particularly recommended when there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers. Suitable for the joining of stainless steels of the 18% Cr-8% Ni type with a low carbon content and Nb-stabilised steels of the same type if the service temperature does not exceed 350°C. It can also be used for welding Cr steels, except in sulphur-rich environments.

Welding current

DC(-)

Classifications	Approvals		Typical all weld metal composition, %		Typical mech. properties all weld metal	
<u>EN ISO 14343</u> W 19 9 L <u>SFA/AWS A5.9</u> ER308L <u>Werkstoffnummer</u> ~1.4316	DNV	308L (-60°C)	C	0,01	<u>Yield stress, MPa</u>	
			C	0,030	450	
			Si	0,4	<u>Tensile strength, MPa</u>	
	UDT	DIN 8556	Si	0,475	645	
			VdTÜV 04269		<u>Elongation, %</u>	
	CWB	AWS A5.9 (Item no ending with A)	Mn	1,8	36	
			Mn	1,75	<u>Elongation, %</u>	
			Cr	20,25	36	
			P	0,020	<u>Charpy V</u>	
			Ni	10	<u>Test temps, °C</u>	<u>Impact values, J</u>
			S	0,015	+20	170
			Cr	20	-80	135
			Mo	0,3	-196	90
			Cu	0,3		
			Ni	10		

		Mo	0,1	
		N	0,08	
		Cu	0,1	
		P	0,030	
		S	0,020	
		Wire composition		

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

OK Tigrod 309L

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OK Tigrod 309L

GTAW

Bare, corrosion-resistant, chromium-nickel welding rod for welding the 24%Cr, 13%Ni-alloyed types of steel. The alloy is also used for welding buffer layers on CMn steels and welding dissimilar joints. When using the wire for buffer layers and dissimilar joints, it is necessary to control the dilution of the weld. OK Tigrod 309L has good general corrosion resistance. When used for joining dissimilar materials, the corrosion resistance is of secondary importance.

Welding current

DC(-)

Classifications	Approvals	Typical all weld metal composition, %		Typical mech. properties all weld metal		
<u>EN ISO 14343</u> W 23 12 L <u>SFA/AWS A5.9</u> ER309L <u>Werkstoffnummer</u> ~1.4332	VdTÜV 10021	C	<0,03	<u>Yield stress, MPa</u> 430		
	CE	EN 13479	Si	0,5	<u>Tensile strength, MPa</u> 590	
			Mn	1,8	<u>Elongation, %</u> 40	
	CWB	AWS A5.9 (Item no ending with A)	Cr	24,0	<u>Elongation, %</u> 40	
			Ni	13,0	<u>Charpy V</u>	
			Mo	<0,3	<u>Test temps, °C</u>	<u>Impact values, J</u>
	Cu	<0,3				
			Wire composition		+20	160
					-60	130
					-110	90

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