



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 12.64

Prepared by Mats Linde	Qualified by P-O Oskarsson	Approved by Helene Rasmuson	Reg no EN007517	Cancelling EN007384	Reg date 2017-04-06	Page 1 (2)
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## REASON FOR ISSUE

Mechanical data updated.

## GENERAL

A copper coated, G4Si1/ER70S-6 rod for GTAW of general structural and engineering unalloyed and low-alloyed carbon-manganese steels. Compared with OK Tigrod 12.61, OK Tigrod 12.64 has a slightly higher silicon and manganese content, which increases the weld metal strength. The high silicon content promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

**Shielding Gas:** I1 (EN ISO 14175)

**Alloy Type:** Carbon-manganese steel

### CLASSIFICATIONS Weld Metal

EN ISO 636-A W 46 4 4Si1

### CLASSIFICATIONS Wire Electrode

EN ISO 636-A W4Si1  
SFA/AWS A5.18 ER70S-6

### APPROVALS

ABS	3Y (I1)
BV	3YM (I1)
CE	EN 13479
DNV-GL	III YM (I1)
LR	3Ym H15 (I1)
NAKS/HAKC	1.6MM-2.4MM
VdTÜV	05260

### APPROVAL COMMENT

Valid for lot numbers starting with PV

## CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.08	0.06	0.12
Si	0.80	0.80	1.15
Mn	1.28	1.60	1.85
P	0.015		0.025
S	0.013		0.025

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal					
	Ar (I1) EN			Ar (I1) AWS		Ar (I1) AWS
	Min	Max	Typ	Min	Typ	Typ
ReL (MPa)	460		525	400	510	400
Rm (MPa)	530	680	595	480	610	525
A4-A5 (%)	20		26	22	30	32
Charpy V at -30°C (J)				27		
Charpy V at -40°C (J)	47		150			
Charpy V at -46°C (J)					100	80



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### OTHER DATA

Length of rods: 1000 mm.

Dimensions available are: 1.6, 2.0, 2.4, 3.0 and 3.2 mm.

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

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