



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 13.08

| | | | | | | |
|---------------------------|------------------------------|-----------------------------------|--------------------|------------------------|------------------------|---------------|
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REASON FOR ISSUE

Cu content updated

GENERAL

A copper coated, low alloyed, manganese-molybdenum (1,5% Mn, 0,4% Mo) rod for GTAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers with a working temperature of up to about 500°C. The rod can also be used for welding low-alloyed high tensile strength steels.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Low alloyed steel (0.5 % Mo)

CLASSIFICATIONS Weld Metal

EN ISO 636-B W55 3 W4M31

APPROVALS

Not applicable

CLASSIFICATIONS Wire Electrode

EN ISO 636-B W4M31
SFA/AWS A5.28 ER80S-D2

CHEMICAL COMPOSITION

Wire/Strip (%)

| | Min | Max |
|------------|------|-------|
| C | 0.06 | 0.12 |
| Si | 0.50 | 0.80 |
| Mn | 1.70 | 2.10 |
| P | | 0.025 |
| S | | 0.025 |
| Ni | | 0.15 |
| Mo | 0.40 | 0.60 |
| Cu | | 0.40 |
| Others tot | | 0.50 |

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

| Properties | Ar (I1) AWS | | Ar (I1) EN | |
|--------------|----------------|-----|---------------|-----|
| | Min | Typ | Min | Max |
| Rp0.2 (MPa) | 470 | 520 | 460 | |
| Rm (MPa) | 550 | 615 | 530 | 680 |
| A4-A5 (%) | 24 | 28 | 20 | |
| Z (%) | | 60 | | |
| at -20°C (J) | | | 47 | |
| at -29°C (J) | 27 | 200 | | |

OTHER DATA

Lengths available are: 1000 mm.

Dimensions available are: 1.6 and 2.4mm.

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