



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 13.16

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REASON FOR ISSUE

Mechanical data update.

GENERAL

A copper coated, low-alloyed, chromium-molybdenum (1,3% Cr, 0,5% Mo), rod for GTAW of creep resistant steels like SA-387 Grade 11, A 335 Grade P11 or similar materials. OK Tigrod 13.16 is a high purity wire.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Low alloyed steel (1,3%Cr, 0.5 % Mo)

CLASSIFICATIONS Wire Electrode

EN ISO 21952-A Z CrMo1Si
EN ISO 21952-B W 55 1CM
SFA/AWS A5.28 ER80S-B2

APPROVALS

CE EN 13479

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar			
C	0.08	0.07	0.12
Si	0.5	0.40	0.70
Mn	0.5	0.40	0.70
P	0.010		0.025
S	0.01		0.020
Cr	1.3	1.20	1.50
Ni			0.20
Mo	0.5	0.40	0.65
Cu	0.15		0.35
X			15
Others tot			0.50

Comments:
 $X = (10P+5Sb+4Sn+As)/100$
(values in ppm)

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Min	Typ
	Ar (I1) AWS	
	Stress relieved 620°C 1h	
Rp0.2 (MPa)	470	640
Rm (MPa)	550	730
A4 (%)	19	24
at -40°C (J)	47	