



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 13.28

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REASON FOR ISSUE

EN ISO 636-A classification upgraded to W 46 6 W2Ni2

GENERAL

A copper coated, Ni-alloyed (2,4% Ni), rod for GTAW of low-alloyed and low temperature steels in applications such as vessels, pipes and in the offshore industry with a minimum yield strength less than 470 Mpa. The wire provides a good impact toughness down to -60 °C

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Low alloyed steel (2.8 % Ni)

CLASSIFICATIONS Weld Metal

EN ISO 636-A W 46 6 W2Ni2

APPROVALS

VdTÜV 06243 (RG)

CLASSIFICATIONS Wire Electrode

EN ISO 636-A W2Ni2

SFA/AWS A5.28 ER80S-Ni2

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.10	0.06	0.12
Si	0.6	0.40	0.80
Mn	1.1	0.90	1.25
P	0.015		0.025
S	0.015		0.025
Ni	2.4	2.00	2.75
Cu	0.15		0.35
Others tot			0.50

Comments:
Others tot. according to applicable AWS standard

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal					
	Ar AWS		Ar AWS		Ar AWS	
	As welded		Stress relieved 620°C 1h		Stress relieved 620°C 1h	
	Typ	Min	Typ	Min	Typ	
Rp0.2 (MPa)	495	470	515	470	515	
Rm (MPa)	600	550	585	550	585	
A4 (%)	31	24	30	24	30	
Charpy V at -60°C (J)	180	27	150	27	150	
Charpy V at -101°C (J)			150		150	