



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 16.95

Prepared by Mats Linde	Approved by Mikael Mimer/Christos Skodras	Reg no EN005376	Cancelling EN005058	Reg date 2011-04-18	Page 1 (2)
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## REASON FOR ISSUE

Change in specification

## GENERAL

Bare corrosion resisting chromium-nickel-manganese welding rods for welding of austenitic stainless alloys of 18% Cr, 8% Ni, 7% Mn types.

OK Tigrod 16.95 has a 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 joining of austenitic, manganese, work hardenable steels as well as armourplate and heat resistant steels.

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

**Alloy Type:** Austenitic (18 % Cr - 8 % Ni - 7 % Mn)

## CLASSIFICATIONS Wire Electrode

EN ISO 14343 W 18 8 Mn

Werkstoffnummer ~1.4370

## APPROVALS

CE EN 13479

DB 43.039.12

VdTÜV 05421

## CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.08		0.20
Si	0.7	0.6	1.2
Mn	6.5	5.5	7.5
P	0.010		0.030
S	0.020		0.020
Cr	18.5	17.0	20.0
Ni	8.5	7.0	10.0
Mo	0.1		0.5
Cu	0.1		0.5
N			0.08
Others tot			0.50

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	
	Min	Typ
Rp0.2 (MPa)	350	450
Rm (MPa)	500	640
A4-A5 (%)	25	41
Charpy V at 20°C (J)		130



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### OTHER DATA

Dimensions available are: 1.2 , 1.6 , 2.0 , 2.4 , 3.2 mm.

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

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