



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod NiCrMo-13

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## REASON FOR ISSUE

Product name changed from OK Tigrod 19.81 to OK Tigrod NiCrMo-13

## GENERAL

Bare Ni-Cr-Mo rods for welding of high alloyed Ni-base materials, 9 %Ni steel and super austenitic steels of type 20Cr-25Ni with 4-6 % Mo. Can also be used for welding carbon steel to Ni base steel. The weld metal has a very good toughness and is corrosion resistant over a wide range of applications in oxidizing and reducing media.

**Shielding Gas:** I1, R1 (EN 439)

**Alloy Type:** Alloyed nickel (Ni + 23 % Cr + 16 % Mo)

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.14    ERNiCrMo-13  
EN ISO 18274    S Ni 6059 (NiCr23Mo16)

## APPROVALS

VdTÜV                    12663 (MV)

## CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.002		0.010
Si	0.03		0.10
Mn	0.15		0.5
P	0.003		0.015
S	0.002		0.005
Cr	22.7	22.0	24.0
Ni		56.0	
Mo	15.4	15.0	16.5
Co	0.02		0.3
Al	0.15	0.1	0.4
Fe	0.5		1.5
Others tot			0.50
	Comments: Ni balance		

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Typ
Rp0.2 (MPa)	500	
Rm (MPa)	750	
A4-A5 (%)	40	
at -110°C (J)	120	

## OTHER DATA

Delivery form: Boxes of 5.0 kg net weight.