# OK Tigrod 13.12

OK Tigrod 13.12 is a 1.0Cr-0.5Mo-alloyed, copper-coated rod for the GTAW of creep-resistant steels of the same type, such as pipes in pressure vessels and boilers. The rod can also be used for welding low-alloyed, high strength steels with a minimum tensile strength of 550 MPa.

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|---|---|
| **Classifications Wire Electrode:** | SFA/AWS A5.28:ER80S-G, EN ISO 21952-A:W CrMo1Si, EN ISO 21952-B:W 55 1CM3 |
| **Approvals:** | NAKS/HAKC 2.4mm, VdTÜV 04952 |

*Approvals are based on factory location. Please contact ESAB for more information.*

| | |
|---|---|
| **Alloy Type:** | Low alloyed steel (1 % Cr - 0.5 % Mo) |

## Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|---|---|---|---|
| **Ar (I1) AWS** | | | |
| As welded | 560 MPa | 720 MPa | 24 % |
| **Ar (I1) EN** | | | |
| Stress relieved 0,5 hr 700 °C | 560 MPa | 650 MPa | 26 % |

## Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|---|---|---|
| **Ar (I1) AWS** | | |
| As welded | 20 °C | 120 J |
| As welded | -20 °C | 50 J |
| As welded | -30 °C | 40 J |
| As welded | -40 °C | 20 J |
| As welded | -60 °C | 20 J |
| **Ar (I1) EN** | | |
| Stress relieved 0,5 hr 700 °C | 20 °C | 180 J |

## Typical Wire Composition %

| C | Mn | Si | Ni | Cr | Mo |
|---|---|---|---|---|---|
| 0.09 | 1.00 | 0.65 | 0.02 | 1.18 | 0.49 |