

# OK Tigrod 13.26

A copper coated, low alloyed, nickel copper (0,8% Ni, 0,3 %Cu) rod for the GTAW of weathering steels such as COR-TEN, Patinax, Dillicor etc. The weld metal composition and mechanical properties also make this product suitable for welding high strength steels with a minimum yield strength less than 470 Mpa.

<b>Classifications Weld Metal:</b>	EN ISO 636-A:W46 6 W3Ni1
<b>Classifications Wire Electrode:</b>	SFA/AWS A5.28:ER80S-G, EN ISO 636-A:W3Ni1
<b>Approvals:</b>	CE EN 13479, DNV IV YM*

\*Valid for lot numbers starting with PV. Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type:</b>	Low alloyed steel (0.8 % Ni - 0.4 % Cu)
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## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>Ar (I1) AWS</b>			
Stress relieved 2 hr 650 °C	430 MPa	545 MPa	32 %
<b>Ar (I1) EN</b>			
As welded	490 MPa	580 MPa	30 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>Ar (I1) AWS</b>		
Stress relieved 2 hr 650 °C	20 °C	230 J
Stress relieved 2 hr 650 °C	-20 °C	210 J
Stress relieved 2 hr 650 °C	-40 °C	170 J
Stress relieved 2 hr 650 °C	-60 °C	160 J
<b>Ar (I1) EN</b>		
As welded	20 °C	200 J
As welded	-20 °C	140 J
As welded	-40 °C	60 J
As welded	-60 °C	100 J

## Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.095	1.32	0.80	0.8	0.06	0.006	0.5