



# Product Data Sheet

W 'Tungsten inert gas arc welding'

## OK Tigrod 13.23

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### REASON FOR ISSUE

NAKS/HAKC added and mechanical data updated.

### GENERAL

A copper coated, Ni-alloyed (0,9% Ni), rod for GTAW of low-temperature fine-grained steels. The wire provides good impact toughness down to -50 °C and is especially suitable for use in the offshore industry.

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

**Alloy Type:** Low alloyed steel (1 % Ni)

### CLASSIFICATIONS Wire Electrode

SFA/AWS A5.28 ER80S-Ni1

### APPROVALS

DNV-GL IV Y40M (I1)  
NAKS/HAKC 2.0MM-2.4MM

### CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar (I1)			
C	0.08	0.05	0.12
Si	0.7	0.40	0.80
Mn	1.0	0.80	1.20
P	0.01		0.025
S	0.01		0.025
Cr	0.01		0.15
Ni	0.9	0.80	1.00
Mo	0.25	0.20	0.35
V	0.01		0.05
Cu	0.15		0.35
Others tot			0.50

### MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Min	Typ
	Ar (I1) AWS	
	As welded	
Rp0.2 (MPa)	470	500
ReL (MPa)		500
Rm (MPa)	550	600
A4-A5 (%)	24	25
Charpy V at 0°C (J)		230
Charpy V at -20°C (J)		200
Charpy V at -46°C (J)	27	140
Charpy V at -60°C (J)		90

### OTHER DATA

Lengths available are: 1000 mm.

Dimensions available are: 1.6, 2.0, 2.4, and 3.2.

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