



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 55

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Per-Erik Andersson	Reg no EN006073	Cancelling EN005231	Reg date 2013-05-08	Page 1 (2)
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REASON FOR ISSUE

Mechanical typical values updated.

GENERAL

A copper coated, low alloyed, chromium-nickel-molybdenum (0,5% Cr, 0,5% Ni, 0,2% Mo) rod for GTAW of high strength steels with a minimum tensile strength of 690 MPa. The rod is also suitable for welding of steels where a good impact strength at low temperatures is required.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Low alloyed steel (0.5 % Cr - 0.5 % Ni - 0.2 % Mo)

CLASSIFICATIONS Weld Metal (as welded)

EN ISO 16834-A W 55 4 Mn3NiCrMo

APPROVALS

Not applicable

CLASSIFICATIONS Wire Electrode

EN ISO 16834-A Mn3NiCrMo

SFA/AWS A5.28 ER100S-G

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.1	0.07	0.14
Si	0.7	0.6	0.8
Mn	1.4	1.30	1.50
P	0.015		0.020
S	0.015		0.020
Cr	0.5	0.50	0.65
Ni	0.5	0.50	0.65
Mo	0.2	0.15	0.30
Cu	0.15		0.30
Others tot			0.25

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			Ar (I1) EN			Ar (I1) EN		
	As welded			As welded			Stress relieved 620°C 2h		
	Min	Typ	Min	Max	Typ	Min	Max	Typ	
Rp0.2 (MPa)		636	550		720			629	
Rm (MPa)	690	713	640	820	817			716	
A4-A5 (%)	16	16							
A5 (%)			18		21			23	
at -30°C (J)		123			129			140	
at -40°C (J)		86	47		120			79	
	Comments: Tested at 20°C			Comments:			Comments:		



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OTHER DATA

Lengths available are: 1000 mm.

Dimensions available are: 1.6, 2.0 and 2.4 mm.

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