

OK Tigrod 12.64

OK Tigrod 12.64 is a copper-coated Mn-Si-alloyed W4Si1/ER70S-6 solid rod for the GTAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding. It has a slightly higher manganese and silicon content than OK Tigrod 12.61 to increase the weld metal strength. This also promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

Classifications Weld Metal:	EN ISO 636-A:W 46 3 W4Si1
Classifications Wire Electrode:	SFA/AWS A5.18:ER70S-6, EN ISO 636-A:W4Si1
Approvals:	CE EN 13479, DNV III YM (I1), ABS 3Y (I1), BV 3YM (I1), GL 3Y (I1), LR 3Ym H15 (I1), NAKS/HAKC 1.6MM-2.4MM, VdTÜV 05260

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

Alloy Type:	Carbon-manganese steel
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Ar (I1) EN			
As welded	525 MPa	595 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Ar (I1) EN		
As welded	-30 °C	70 J

Typical Wire Composition %

C	Mn	Si
0.074	1.68	0.95