OK Tigrod 13.22

OK Tigrod 13.22 is a 2.5Cr-1.0Mo-alloyed, copper-coated rod for the GTAW of creep-resistant steels such as pipes in pressure vessels and boilers of similar composition, with service temperatures of up to 600°C, but it is also suitable for welding high strength steels.

Classifications Wire Electrode:	SFA/AWS A5.28:ER90S-G, EN ISO 21952-A:W CrMo2Si, EN ISO 21952-B:W 62 2C1M3
Approvals:	NAKS/HAKC 2.0MM, VdTÜV 11884

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

Alloy Type:	Low alloyed steel (2.5 % Cr - 1.0 % Mo)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS and EN I1 (Ar)			
Stress relieved 1 hr 690 °C	550 MPa	655 MPa	24 %
EN I1 (Ar)			
Stress relieved 1 hr 720 °C	530 MPa	640 MPa	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS and EN I1 (Ar)		
Stress relieved 1 hr 690 °C	20 °C	190 J
EN I1 (Ar)		
Stress relieved 1 hr 720 °C	20 °C	120 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.07	1.02	0.61	0.08	2.45	1.01