

# OK Tigrod 13.09 GTAW

ER80S-G

## Description

OK Tigrod 13.09 is a 0.5Mo-alloyed, copper-coated rod for the GTAW of creep-resistant steels of the same type, such as pipes in pressure vessels and boilers with a working temperature of up to about 500°C.

## Welding current

DC(-)

## Classifications

SFA/AWS A5.28	ER80S-G
EN 1668	W2Mo
EN 12070	W MoSi

## Wire composition

C	Si	Mn	Mo
0.1	0.5	1.1	0.5

## Typical mech. properties all weld metal

Yield stress, MPa	540
Tensile strength, MPa	630
Elongation, %	25

## Charpy V

Test temps, °C	Impact values, J
+20	180
-20	130
-40	90
-60	25

## Approvals

DB	42.039.08
DNV	IIIYMS
UDT	DIN 8575
Ü	42.039/2
VdTÜV	04950

## Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.0	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0
4.0	1000	5.0