

OK Tigrod 13.32 GTAW

ER80S-B6

Description

OK Tigrod 13.32 is a 5Cr-0.5Mo-alloyed (ER80S-B6), copper-coated rod for the GTAW of creep-resistant steels of similar composition. The rod is also suitable for welding high strength steels with a minimum yield strength of up to 730 MPa.

AWS has changed the classification for this product. The previous classification was A5.9 ER502.

Welding current

DC(-)

Classifications

SFA/AWS A5.28	ER80S-B6
DIN 8575	W.nr. 1.7373
EN 12070	WCrMo5

Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu
0.07	0.4	0.6	5.8	<0.3	0.6	<0.4

Typical mech. properties all weld metal

Yield stress, MPa	730
Tensile strength, MPa	900
Elongation, %	22

Charpy V

Test temps, °C	Impact values, J
+20	100
-20	80
-29	50

Packing data

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