

OK Tigrod 19.85 GTAW

ERNiCr-3

Description

A nickel-based, corrosion- and heat-resistant, 20% Cr, 3% Mn, 2.5% Nb rod for the GTAW of high-alloyed steel, heat-resistant steel, corrosion-resistant steel, 9% Ni steels and similar steels with high notch toughness at low temperatures. It is also suitable for joining dissimilar metals of the types mentioned above. OK Tigrod 19.85 is usually welded with pure Ar as the shielding gas.

Welding current

DC(-)

Classifications

SFA/AWS A5.14 ERNiCr-3
EN ISO 18274 S Ni 6082
(NiCr20Mn3Nb)

Wire composition

C	Si	Mn	Cr	Ni	Cu	Ti	Fe
<0.1	<0.5	3.0	20.0	>67.0	<0.5	<0.7	<3.0

Typical mech. properties all weld metal

Yield stress, MPa 440
Tensile strength, MPa 670
Elongation, % 40

Charpy V

Test temps, °C	Impact values, J
+20	150
-196	100

Approvals

UDT DIN 1736
VdTÜV

Packing data

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5
2.0	1000	5
2.4	1000	5
3.2	1000	5