

## Spoolarc 75 Tigrod

Spoolarc 75 Tigrod is a copper-coated 1% nickel solid rod for carbon steel and low alloy welding applications using either the MIG/Gas Metal Arc Welding (GMAW). Spoolarc 75 produces a deposit that meets the weathering requirements of AWS D1.1 and D1.5 and is designed to weld weathering steels and/or where improved low temperature impact toughness is specified. Shielding gas choices for Spoolarc 75 are Ar/CO<sub>2</sub> mixtures containing a minimum of 75% Ar or the 98% Ar/2% O<sub>2</sub>. Spoolarc 75 is used for bridge and structural welding.

### Specifications

<b>Classifications</b>	ASME SFA 5.28 ASME SFA 5.23 AWS A5.28 : ER80S-Ni1 AWS A5.23 : ENi1K
<b>Industry</b>	Mobile Equipment Ship/Barge Building Industrial and General Fabrication Bridge Construction

### Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.08	0.94	0.49	0.002	0.01	0.98	0.04	0.01	0.08