

OK Tigrod 55

A copper coated, low alloyed, chromium-nickel-molybdenum (0,5% Cr, 0,5% Ni, 0,2% Mo) rod for GTAW of high strength steels with a minimum tensile strength of 690 MPa. The rod is also suitable for welding of steels where a good impact strength at low temperatures is required.

Specifications

Classifications	EN ISO 16834-A : W 55 4 Mn3NiCrMo EN ISO 16834-A : Mn3NiCrMo SFA/AWS A5.28 : ER100S-G
Approvals	CE : EN 13479 UKCA : EN 13479

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

Alloy Type	Low alloyed steel (0.5 % Cr - 0.5 % Ni - 0.2 % Mo)
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Ar(I1) AWS			
As Welded	636 MPa	713 MPa	16 %
Ar (I1) EN			
Stress Relieved 2 hour(s) 620 °C	629 MPa	716 MPa	23 %
As Welded	720 MPa	817 MPa	21 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Ar(I1) AWS		
As Welded	-30 °C	120 J
As Welded	-40 °C	85 J
As Welded	-50 °C	80 J
Ar (I1) EN		
As Welded	-30 °C	125 J
As Welded	-50 °C	75 J
Stress Relieved	-30 °C	140 J
Stress Relieved	-40 °C	75 J
As Welded	-40 °C	120 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.118	1.38	0.71	0.52	0.57	0.19

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.1	1.4	0.7	0.015	0.015	0.5	0.5	0.2	0.15