OK Tigrod 13.26

A copper coated, low-alloyed, nickel-copper (0,8% Ni, 0,45% Cu), rod for GTAW of weathering steels, such as COR-TEN, Patinax, Dillicor etc. According to NACE it would be acceptable to use these welding consumables, since the nickel content is below the maximum acceptable level, 1 % for sour gas applications. One other requirement from NACE is the maximum hardness of the deposited weld metal, which must not exceed 22 HRC. The weld metal composition and mechanical properties also make this product suitable for welding high strength steels with a minimum yield strength less than 470 MPa.

Specifications	
Classifications	EN ISO 636-A : W 46 6 Z 3Ni1Cu EN ISO 636-A : W Z 3Ni1Cu SFA/AWS A5.28 : ER80S-G
Approvals	CE : EN 13479 DNV-GL : IV YM (I1) UKCA : EN 13479

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

Alloy Type	Low alloyed steel (0.8 % Ni - 0.4 % Cu)
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
EN I1			
As Welded	490 MPa	580 MPa	30 %
AWS I1			
Stress Relieved 2 hour(s) 650 °C	430 MPa	545 MPa	32 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
EN I1		
As Welded	-60 °C	60 J
As Welded	-40 °C	100 J
As Welded	-20 °C	140 J
As Welded	20 °C	200 J
AWS I1		
Stress Relieved	20 °C	230 J
Stress Relieved	-60 °C	160 J
Stress Relieved	-20 °C	210 J
Stress Relieved	-40 °C	170 J

Typical Wire Composition %						
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**Cu**
0.095	1.32	0.80	0.8	0.06	0.006	0.5

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cu**
0.07	1.3	0.7	0.015	0.015	0.8	0.35