

OK Tigrod 13.28

A copper coated, Ni-alloyed (2,4% Ni), rod for GTAW of low-alloyed and low temperature steels in applications such as vessels, pipes and in the offshore industry with a minimum yield strength less than 470 Mpa. The wire provides a good impact toughness down to -60 C

Specifications

Classifications	EN ISO 636-A : W 46 6 2Ni2 EN ISO 636-A : W 2Ni2 SFA/AWS A5.28 : ER80S-Ni2
Approvals	NAKS/HAKC : 2.0-2.4 mm VdTÜV : 06243 (RG)

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

Alloy Type	Low alloyed steel (2.8 % Ni)
Shielding Gas	I1 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
I1 AWS			
Stress Relieved 1 hour(s) 620 °C	515 MPa	585 MPa	30 %
As Welded	495 MPa	600 MPa	31 %
I1 EN			
As Welded	540 MPa	630 MPa	30 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
I1 AWS		
Stress Relieved	-60 °C	150 J
As Welded	-60 °C	180 J
Stress Relieved	-101 °C	150 J
I1 EN		
As Welded	-60 °C	150 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr
0.08	1.04	0.53	2.36	0.03

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cu
0.10	1.1	0.6	0.015	0.015	2.4	0.15