

OK Tigrod 13.32

A copper coated, low-alloyed, chromium-molybdenum (5% Cr, 0.5% Mo), rod for GTAW of creep resistant steels of similar composition. Also suitable in welding of high strength steels with a minimum yield strength less than 730 Mpa. AWS have changed the classification for this product, earlier classification was A5.9 ER502.

Specifications

Classifications	EN ISO 21952-A : W CrMo5Si EN ISO 21952-B : W 55 5CM SFA/AWS A5.28 : ER80S-B6
Approvals	NAKS/HAKC : 2.0-2.4MM

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

Alloy Type	Low alloyed steel (5 % Cr - 0.5 % Mo)
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
EN I1			
Stress Relieved 1 hour(s) 730-760 °C	550 MPa	640 MPa	23 %
Stress relieved++ 1 hour(s) 730-760 °C	430 MPa	477 MPa	19 %
Stress relieved+ 1 hour(s) 730-760 °C	465 MPa	527 MPa	18 %
AWS I1			
As Welded	730 MPa	900 MPa	22 %
Stress Relieved 1 hour(s) 745 °C	580 MPa	680 MPa	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
EN I1		
Stress Relieved	20 °C	250 J
AWS I1		
Stress Relieved	-20 °C	200 J
Stress Relieved	-29 °C	200 J
As Welded	20 °C	100 J
Stress Relieved	20 °C	230 J
As Welded	-20 °C	80 J
As Welded	-29 °C	50 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.07	0.48	0.44	0.06	5.73	0.58

Deposition Data

Diameter	Current	Wire Feed Speed	Deposition Rate
1.6 mm	40-180 A	0.0-0.0 m/min	0.0-0.0 kg/h
2.0 mm	60-200 A	0.0-0.0 m/min	0.0-0.0 kg/h
2.4 mm	100-220 A	0.0-0.0 m/min	0.0-0.0 kg/h
3.2 mm	130-250 A	0.0-0.0 m/min	0.0-0.0 kg/h

OK Tigrod 13.32

Recommended Welding Parameters

Current	Wire Diameter
60-200 A	2.0 mm
100-220 A	2.4 mm
130-250 A	3.2 mm