OK Tigrod 12.60

A copper coated, manganese-silicon alloyed rod for GTAW of all general engineering and structural steels with a minimum yield strength of 380 MPa. The rod is usually welded with pure argon (I1) as the shielding gas.

Specifications	
Classifications	EN ISO 636-A : W 38 4 2Si EN ISO 636-A : W 2Si SFA/AWS A5.18 : ER70S-3
Approvals	ABS : 3Y ABS : ER 70S-3 BV : 3YM CE : EN 13479 DNV-GL : III YM (I1) UKCA : EN 13479 VdTÜV : 11141

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

Alloy Type	Carbon-manganese steel
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
Ar (I1) AWS			
As Welded	450 MPa	540 MPa	33 %
Ar (I1) EN			
As Welded	420 MPa	515 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
Ar (I1) AWS		
As Welded	-20 °C	250 J
As Welded	-50 °C	150 J
Ar (I1) EN		
As Welded	-20 °C	260 J
As Welded	-40 °C	160 J
As Welded	-50 °C	150 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**S**	**P**
Ar				
0.10	1.11	0.72	0.012	0.013

Typical Wire Composition %		
C	**Mn**	**Si**
0.10	1.11	0.72