OK Tigrod 12.61

A copper coated, manganese-silicon alloyed rod for GTAW of all general engineering and structural steels with a minimum yield strength of max 420 MPa. The rod is usually welded with pure argon (I1) as the shielding gas.

Specifications	
Classifications	EN ISO 636-A : W 42 3 3Si1 EN ISO 636-A : W 3Si1 SFA/AWS A5.18 : ER70S-6
Approvals	CE : EN 13479 DB : 42.039.07 DNV : IV Y40M UKCA : EN 13479 VdTÜV : 09124

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) EN			
As Welded	470 MPa	560 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
Ar (I1) EN		
As Welded	-30 °C	70 J
As Welded	-40 °C	60 J

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**S**	**P**
Ar				
0.05	1.4	0.8	0.015	0.015

Typical Wire Composition %		
C	**Mn**	**Si**
0.078	1.46	0.85