OK Tigrod 13.23

A copper coated, Ni and Mo-alloyed (0,9% Ni, 0,3% Mo), rod for GTAW of low-temperature fine-grained steels. The wire provides good impact toughness down to -50 C and is especially suitable for use in the offshore industry.

Specifications	
Classifications	EN ISO 636-A : W 46 5 Z3Ni1 EN ISO 636-A : W Z3Ni1 SFA/AWS A5.28 : ER80S-Ni1
Approvals	CE : EN 13479 DNV : IV Y40M (I1) UKCA : EN 13479

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

Alloy Type	Low alloyed steel (1% Ni, 0,3% Mo)
Shielding Gas	I1 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
Ar (I1) EN ISO			
As Welded	500 MPa	600 MPa	27 %
Ar (I1) AWS			
As Welded	500 MPa	600 MPa	25 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
Ar (I1) EN ISO		
As Welded	-50 °C	130 J
As Welded	-60 °C	80 J
Ar (I1) AWS		
As Welded	0 °C	230 J
As Welded	-20 °C	200 J
As Welded	-46 °C	140 J
As Welded	-60 °C	90 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Cu**
Ar (I1)									
0.08	1.0	0.7	0.01	0.01	0.9	0.01	0.25	0.01	0.15
-	-	-	-	-	-	0.01	-	-	-

Typical Wire Composition %				
C	**Mn**	**Si**	**Ni**	**Mo**
0.07	1.11	0.57	0.9	0.29