

## OK Tigrod 12.64

A copper coated, G4Si1/ER70S-6 rod for GTAW of general structural and engineering unalloyed and low-alloyed carbon-manganese steels. Compared with OK Tigrod 12.61, OK Tigrod 12.64 has a slightly higher silicon and manganese content, which increases the weld metal strength. The high silicon content promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

<b>Classifications Weld Metal</b>	EN ISO 636-A : W 46 5 4Si1
<b>Classifications Wire Electrode</b>	SFA/AWS A5.18 : ER70S-6 EN ISO 636-A : W 4Si1
<b>Approvals</b>	ABS 3Y (I1) BV 3YM CE EN 13479 DNV-GL III YM (I1) LR 3Ym H15 (I1) NAKS/HAKC 1.6MM-2.4MM VdTUV 05260

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

<b>Alloy Type</b>	Carbon-manganese steel
<b>Shielding Gas</b>	I1 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>Ar (I1) EN</b>			
As Welded	525 MPa	595 MPa	26 %
<b>Ar (I1) AWS</b>			
As Welded	510 MPa	610 MPa	30 %
Stress Relieved 2hr 620°C	400 MPa	525 MPa	32 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>Ar (I1) EN</b>		
As Welded	-40 °C	150 J
As Welded	-50 °C	90 J
<b>Ar (I1) AWS</b>		
As Welded	-46 °C	100 J
Stress Relieved 2hr 620°C	-46 °C	80 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.08	1.28	0.80	0.013	0.015

### Typical Wire Composition %

C	Mn	Si
0.074	1.68	0.95