

OK Tigrod 13.22 GTAW

ER90S-G

Description

OK Tigrod 13.22 is a 2.5Cr-1.0Mo-alloyed, copper-coated rod for the GTAW of creep-resistant steels such as pipes in pressure vessels and boilers of similar composition, with service temperatures of up to 600°C, but it is also suitable for welding high strength steels.

Welding current

DC(-)

Classifications

SFA/AWS A5.28	ER90S-G
DIN 8575	W.nr 1.7384
EN 12070	W CrMo2Si

Wire composition

C	Si	Mn	Cr	Mo
0.08	0.7	1.0	2.6	1.0

Typical mech. properties all weld metal

	SR 750°C/0.5h
Yield stress, MPa	>400
Tensile strength, MPa	>500
Elongation, %	>18

Charpy V

Test temps, °C	Impact values, J
+20	200

Approvals

Sepros	UNA 046731
UDT	EN 12070
VdTÜV	

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.0	1000	5.0
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0
4.0	1000	5.0