

OK Tigrod 13.23 GTAW

ER80S-Ni1

Description

OK Tigrod 13.23 is a 0.9Ni-alloyed (ER80S-Ni1), copper-coated rod for the GTA 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.

Welding current

DC(-)

Classifications

SFA/AWS A5.28 ER80S-Ni1

Wire composition

C	Si	Mn	Ni	Mo
0.08	0.6	1.0	0.9	0.3

Typical mech. properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	600
Elongation, %	25

Charpy V

Test temps, °C	Impact values, J
0	230
-20	200
-46	140
-60	90

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