

OK Tigrod 13.32

OK Tigrod 13.32 is a 5Cr-0.5Mo-alloyed (ER80S-B6), copper-coated rod for the GTAW of creep-resistant steels of similar composition. The rod is also suitable for welding high strength steels with a minimum yield strength of up to 730 MPa. AWS has changed the classification for this product. The previous classification was A5.9 ER502.

Specifications

Classifications	EN ISO 21952-A : W CrMo5Si EN ISO 21952-B : W 55 5CM SFA/AWS A5.28 : ER80S-B6
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Alloy Type	Low alloyed steel (5 % Cr - 0.5 % Mo)
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Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
Ar (I1) AWS			
As Welded	730 MPa	900 MPa	22 %
Stress Relieved 1 hour(s) 745 °C	580 MPa	680 MPa	22 %
Ar (I1) EN			
Stress Relieved 1 hour(s) 730-760 °C	465 MPa	527 MPa	18 %
Stress Relieved 1 hour(s) 730-760 °C	550 MPa	640 MPa	23 %
Stress Relieved 1 hour(s) 730-760 °C	430 MPa	477 MPa	19 %

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.07	0.48	0.44	0.06	5.73	0.58

Deposition Data

Diameter	Amps	Wire Feed Speed	Deposition Rate
1.6 mm	40-180 A	0.0-0.0 m/min	0.0-0.0 kg/h
2.0 mm	60-200 A	0.0-0.0 m/min	0.0-0.0 kg/h
2.4 mm	100-220 A	0.0-0.0 m/min	0.0-0.0 kg/h
3.2 mm	130-250 A	0.0-0.0 m/min	0.0-0.0 kg/h