OK Tigrod 13.38 GTAW

ER90S-B9

Description

OK Tigrod 13.38 is a 9CrMoVN-alloyed rod for the GTAW of high-temperature steels and steels for hot hydrogen service, especially in oil refineries. It should preferably be used for 9% Cr steels, such as P 91/T 91 steels.

The alloy is modified in terms of the limits for impurity elements and is extremely "clean". This produces improved strength levels both at room temperature and at higher temperatures.

AWS has changed the classification for this product. The previous classification was A5.9 ER505.

Welding current

DC(-)

Classifications

SFA/AWS A5.28	ER90S-B9
EN 12070	W CrMo91

Wire composition

C	Si	Mn	Cr	Ni	Mo
0.1	0.2	0.5	8.9	0.7	1.0

Typical mech. properties all weld metal

Yield stress, MPa	690
Tensile strength, MPa	785
Elongation, %	20

Charpy V

Test temps, °C	Impact values, J
+20	200
0	180
-20	150
-40	90
-60	70

Approvals

UDT	DIN 8575
VdTÜV	07686

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