OK Tigrod 13.22

A copper coated, low alloyed, chromium-molybdenum (2,5% Cr, 1,0% Mo) rod for GTAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers. The rod can also be used for welding low-alloyed high strength steels with a minimum yield strength less than 400 Mpa. For service temperatures up to 600°C. Similar to AWS A5.28 ER80S-B2.

Specifications	
Classifications	EN ISO 21952-A : W CrMo2Si EN ISO 21952-B : W 62 2C1M3 SFA/AWS A5.28 : ER90S-G
Approvals	NAKS/HAKC : 2.0MM VdTÜV : 11884

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

Alloy Type	Low alloyed steel (2.5 % Cr - 1.0 % Mo)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
EN I1 (Ar)			
Stress Relieved 1 hour(s) 720 °C	530 MPa	640 MPa	24 %
AWS and EN I1 (Ar)			
Stress relieved+ 1 hour(s) 690 °C	550 MPa	655 MPa	24 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
EN I1 (Ar)		
Stress Relieved	20 °C	120 J
AWS and EN I1 (Ar)		
Stress relieved+	20 °C	190 J

Typical Wire Composition %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.07	1.02	0.61	0.08	2.45	1.01

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**S**	**P**	**Cr**	**Mo**
0.06	1.0	0.6	0.015	0.015	2.5	1.0