

OK Tigrod 12.64

GTAW
ER70S-6

Description

OK Tigrod 12.64 is a copper-coated Mn-Si-alloyed W4Si1/ER70S-6 solid rod for the GTAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding. It has a slightly higher manganese and silicon content than OK Tigrod 12.61 to increase the weld metal strength. This also promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

Welding current

DC(-)

Classifications

SFA/AWS A5.18	ER70S-6
EN 1668	W4Si1

Wire composition

C	Si	Mn
0.09	1.0	1.7

Typical properties all weld metal

Yield stress, MPa	525
Tensile strength, MPa	595
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
-30	70

Approvals

ABS	3, 3Y
CL	EN 1668
DNV	III YM(I1)
GL	3Y
LR	3 3Y
UDT	DIN 8559
VdTÜV	05260

Packing data

Diameter, mm	Length, mm	Weight of rods/box, kg
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