

OK Tigrod 12.64

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.

Specifications	
Classifications	EN ISO 636-A : W 46 5 4Si1 EN ISO 636-A : W 4Si1 SFA/AWS A5.18 : ER70S-6
Approvals	ABS : 3Y (I1) BV : 3YM CE : EN 13479 DNV-GL : III YM (I1) LR : 3Y H15 (I1) UKCA : EN 13479 VdTÜV : 05260

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

Alloy Type	Carbon-Manganese
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
Ar (I1) EN			
As Welded	525 MPa	595 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
Ar (I1) EN		
As Welded	-40 °C	150 J

Typical Wire Composition %		
C	Mn	Si
0.074	1.68	0.95

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.08	1.28	0.80	0.013	0.015