

OK Tigrod 13.28

OK Tigrod 13.28 is 2.4Ni-alloyed (ER80S-Ni2), copper-coated rod for the GTAW of low-temperature, fine-grained steels in applications such as pressure vessels, pipes and the offshore industry, with a minimum yield strength of up to 470 MPa. The wire provides good impact toughness down to -60°C.

Specifications

Classifications	EN ISO 636-A : W 46 6 2Ni2 EN ISO 636-A : W 2Ni2 SFA/AWS A5.28 : ER80S-Ni2
Approvals	NAKS/HAKC : 2.0-2.4 mm VdTÜV : 06243 (RG)

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

Alloy Type	Low alloyed steel (2.8 % Ni)
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
Ar AWS				
Stress Relieved 1 hour(s) 260 °C	Stress relieved	515 MPa	585 MPa	30 %
As Welded	As welded	495 MPa	600 MPa	31 %
I1 EN				
As Welded	As welded	540 MPa	630 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Ar AWS		
As Welded	-60 °C	180 J
Stress Relieved	-60 °C	150 J
Stress Relieved	-101 °C	150 J
I1 EN		
As Welded	-60 °C	150 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr
0.08	1.04	0.53	2.36	0.03

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cu
0.10	1.1	0.6	0.015	0.015	2.4	0.15