

# OK Tigrod 13.17 GTAW ER90S-B3

## Description

OK Tigrod 13.17 is a 2.5Cr-1.1Mo-alloyed (ER90S-B3), copper-coated rod for the GMAW of creep-resistant steels like SA-387 Grade 22, A335 Grade P22 or similar materials. The rod has a high purity chemistry with a guaranteed Brucato factor  $X < 15$ .

## Welding current

DC-

## Classifications

SFA/AWS A5.28 ER90S-B3

## Wire composition

C	Si	Mn	Cr	Mo
0.09	0.6	0.6	2.5	1.0

## Typical mech. properties all weld metal

Yield stress, MPa	620
Tensile strength, MPa	730
Elongation, %	22

## Charpy V

Test temps, °C	Impact values, J
-40	>47

## 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