

# OK Tigrod 19.82 GTAW

ERNiCrMo-3

## Description

A nickel-based, corrosion- and heat-resistant, 22% Cr, 9% Mo, 3.5% Nb rod for the GTAW of high-alloyed steel, heat-resistant steel, corrosion-resistant steel, 9% Ni steels and similar steel with high notch toughness at low temperatures. It is also suitable for joining dissimilar metals of the types mentioned above. OK Tigrod 19.82 is normally welded with pure Ar as the shielding gas.

## Welding current

DC(-)

## Classifications

SFA/AWS A5.14	ERNiCrMo-3
EN ISO 18274	S Ni 6625 (NiCr22Mo9Nb)

## Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti	Fe
<0.1	<0.5	<0.5	21.5	>60.0	9.0	<0.5	<0.4	<0.4	<2.0

## Typical mech. properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	780
Elongation, %	40

## Charpy V

Test temps, °C	Impact values, J
+20	130
-105	120
-196	110

## Approvals

UDT	DIN 1736
VdTÜV	

## Packing data

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5
2.0	1000	5
2.4	1000	5
3.2	1000	5