

OK Tigrod 19.92

GTAW
ERNi-1

Description

A nickel-based rod alloyed with 3% Ti for the GTAW of high-purity nickel (min. 99.6% Ni), ordinary wrought nickel and nickel with a reduced carbon content. OK Tigrod 19.92 is normally welded with pure Ar as the shielding gas.

Welding current

DC(-)

Classifications

SFA/AWS A5.14	ERNi-1
DIN 1736	SG NiTi4
Werkstoff Nr.	2.4155

Wire composition

C	Si	Mn	Ti	Ni
0.02	0.3	0.4	3.0	bal.

Typical mech. properties all weld metal

Yield stress, MPa	300
Tensile strength, MPa	500
Elongation, %	27

Charpy V

Test temps, °C	Impact values, J
+20	190
-20	230

Approvals

UDT

Packing data

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