

OK Tigrod 19.93 GTAW

ERNiCu-7

Description

A nickel-based rod alloyed with about 30% Cu, 2% Ti and 1% Fe for the GTAW of base materials of the same type. It can also be used for joining these alloys to steels. OK Tigrod 19.93 is normally welded with pure Ar as the shielding gas.

Welding current

DC(-)

Classifications

SFA/AWS A5.14	ERNiCu-7
DIN 1736	SG-NiCu30MnTi
Werkstoff Nr.	2.4377

Wire composition

C	Si	Mn	Ni	Nb	Cu	Ti	Fe
0.15	<1.0	3.0	65.5	<0.5	30.0	2.3	1.5

Typical mech. properties all weld metal

Yield stress, MPa	300
Tensile strength, MPa	530
Elongation, %	45

Charpy V

Test temps, °C	Impact values, J
+20	130
0	140
-20	150

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