

# OK Tigrod 13.08 GTAW

ER80S-D2

## Description

OK Tigrod 13.08 is a 1.5Mn-0.4Mo-alloyed (ER80S-D2), copper-coated rod for the GTAW of creep-resistant steels of the same type, such as pipes in pressure vessels and boilers with a working temperature of up to about 500°C. The rod can also be used for welding low-alloyed, high tensile strength steels.

## Welding current

DC(-)

## Classifications

SFA/AWS A5.28	ER80S-D2
BS 2901 part 1	A31
EN 1668	W 46 2 W4Mo

## Wire composition

C	Si	Mn	Mo
0.9	0.6	1.9	0.5

## Typical mech. properties all weld metal

Yield stress, MPa	520
Tensile strength, MPa	615
Elongation, %	28

## Charpy V

Test temps, °C	Impact values, J
-29	200

## 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