

## OK Tigrod 12.60

A copper coated, manganese-silicon alloyed rod for GTAW of all general engineering and structural steels with a minimum yield strength of 380 MPa. The rod is usually welded with pure argon (I1) as the shielding gas.

Specifications	
<b>Classifications</b>	EN ISO 636-A : W 38 3 2Si EN ISO 636-A : W 2Si SFA/AWS A5.18 : ER70S-3
<b>Approvals</b>	ABS : 3Y ABS : ER 70S-3 BV : 3YM CE : EN 13479 DNV-GL : III YM (I1) NAKS/HAKC : 1.6-2.4 mm VdTÜV : 11141

<b>Alloy Type</b>	Carbon-manganese steel
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>Ar (I1) AWS</b>			
As Welded	450 MPa	540 MPa	33 %
<b>Ar (I1) EN</b>			
As Welded	420 MPa	515 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>Ar (I1) AWS</b>		
As Welded	-20 °C	250 J
As Welded	-50 °C	150 J
<b>Ar (I1) EN</b>		
As Welded	-20 °C	260 J
As Welded	-30 °C	160 J

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
<b>Ar</b>				
0.10	1.11	0.72	0.012	0.013

Typical Wire Composition %		
C	Mn	Si
0.10	1.11	0.72