

# OK Tigrod 12.64

GTAW  
ER70S-6

## Description

OK Tigrod 12.64 is a copper-coated Mn-Si-alloyed W4Si1/ER70S-6 solid rod for the GTAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding. It has a slightly higher manganese and silicon content than OK Tigrod 12.61 to increase the weld metal strength. This also promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

## Welding current

DC (-)

## Classifications

SFA/AWS A5.18	ER70S-6
EN 1668	W4Si1

## Typical all weld metal composition, %

C	Si	Mn
0.09	1.0	1.7

## Typical properties of all weld metal

Yield stress, Mpa	525
Tensile strength, MPa	595
Elongation, %	26

## Charpy V

Test temps, °C	Impact values, J
-30	70

## Approval

ABS	3, 3Y
DNV	III YM (I1)
GL	3Y
LR	3 3Y
VdTUV	05260

## Packing/Ordering Information

Part Number	Dia. mm	Per Pack (kg)	Pallet Weight (kg)
126416R150	1.6	5	900
126420R150	2.0	5	900
126424R150	2.4	5	900
126432R150	3.2	5	900