



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 12.64

Prepared by Mats Linde	Qualified by P-O Oskarsson	Approved by Helene Rasmuson	Reg no EN007517	Cancelling EN007384	Reg date 2017-04-06	Page 1 (2)
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REASON FOR ISSUE

Mechanical data updated.

GENERAL

A copper coated, G4Si1/ER70S-6 rod for GTAW of general structural and engineering unalloyed and low-alloyed carbon-manganese steels. Compared with OK Tigrod 12.61, OK Tigrod 12.64 has a slightly higher silicon and manganese content, which increases the weld metal strength. The high silicon content promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Carbon-manganese steel

CLASSIFICATIONS Weld Metal

EN ISO 636-A W 46 4 4Si1

CLASSIFICATIONS Wire Electrode

EN ISO 636-A W4Si1

SFA/AWS A5.18 ER70S-6

APPROVALS

ABS 3Y (I1)

BV 3YM (I1)

CE EN 13479

DNV-GL III YM (I1)

LR 3Ym H15 (I1)

NAKS/HAKC 1.6MM-2.4MM

VdTÜV 05260

APPROVAL COMMENT

Valid for lot numbers starting with PV

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar			
C	0.08	0.06	0.12
Si	0.80	0.80	1.15
Mn	1.28	1.60	1.85
P	0.015		0.025
S	0.013		0.025

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal					
	Ar (I1) EN			Ar (I1) AWS		Ar (I1) AWS
	As welded			As welded		Stress relieved 620°C 2h
	Min	Max	Typ	Min	Typ	Typ
	ReL (MPa)	460		525	400	510
Rm (MPa)	530	680	595	480	610	525
A4-A5 (%)	20		26	22	30	32
Charpy V at -30°C (J)				27		
Charpy V at -40°C (J)	47		150			
Charpy V at -46°C (J)					100	80



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OTHER DATA

Length of rods: 1000 mm.

Dimensions available are: 1.6, 2.0, 2.4, 3.0 and 3.2 mm.

The wire rods are delivered in boxes of 5.0 kg net weight.
