

OK Tigrod 16.95

Bare corrosion resisting chromium-nickel-manganese welding rods for welding of austenitic stainless alloys of 18% Cr, 8% Ni, 7% Mn types. OK Tigrod 16.95 has a general corrosion resistance similar to that of the corresponding parent metal. The higher silicon content improves the welding properties, such as wetting. When used for joining dissimilar materials the corrosion resistance is of secondary importance. The alloy is used in a wide range of applications across the industry such as joining of austenitic, manganese, work hardenable steels as well as armourplate and heat resistant steels.

Specifications

Classifications	EN ISO 14343-A : W 18 8 Mn SFA/AWS A5.9 : ER307 (mod) Werkstoffnummer : ~1.4370
Approvals	CE : EN 13479 DB : 43.039.12 UKCA : EN 13479 VdTÜV : 05421

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (18 % Cr - 8 % Ni - 7 % Mn)
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	450 MPa	640 MPa	41 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	130 J
As Welded	-60 °C	56 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.08	6.5	0.7	0.020	0.010	8.5	18.5	0.1	0.1

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.08	7.0	0.9	8.1	18.7	0.20	0.10