OK AristoRod 38 Zn

The non copper coated OK AristoRod 38 Zn is a manganese-silicon alloyed solid wire for MIG welding of galvanized steels with an outstanding performance in terms of low porosity, low spatter and low risk of burnthrough. The electrode can be welded with Ar/CO2 gas mixture. OK AristoRod 38 Zn delivered in the unique ESAB Octogonal Marathon Pac is excellent for mechanized welding applications.

Specifications	
Classifications	EN ISO 14341-A : G 42 3 M20 Z 3Si1 EN ISO 14341-A : G 42 3 M21 Z 3Si1 EN ISO 14341-A : G Z 3Si1 SFA/AWS A5.18 : ER70S-G
Approvals	CE : EN 13479 UKCA : EN 13479

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

Alloy Type	Carbon-manganese steel (Mn/Si-alloyed)
Shielding Gas	M20, M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS M21			
As Welded	440 MPa (64 ksi)	540 MPa (78 ksi)	29 %
M21 EN ISO			
As Welded	440 MPa (64 ksi)	540 MPa (78 ksi)	29 %
EN ISO M20			
As Welded	440 MPa (64 ksi)	550 MPa (80 ksi)	30 %
AWS M20			
As Welded	450 MPa (65 ksi)	550 MPa (80 ksi)	30 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS M21		
As Welded	-30 °C (-22 °F)	120 J (89 ft-lb)
M21 EN ISO		
As Welded	-30 °C (-22 °F)	100 J (74 ft-lb)
As Welded	-40 °C (-40 °F)	100 J (74 ft-lb)
EN ISO M20		
As Welded	-30 °C (-22 °F)	110 J (81 ft-lb)
As Welded	-40 °C (-40 °F)	110 J (81 ft-lb)
AWS M20		
As Welded	-30 °C (-22 °F)	140 J (104 ft-lb)

Typical Wire Composition %		
C	**Mn**	**Si**
0.07	1.4	0.8

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**S**	**P**
0.07	1.1	0.6	0.01	0.01

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Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
0.8 mm (0.030 in.)	50-150 A	15-21.5 V	3.2-11.7 m/min (126-461 in./min)	0.72-2.66 kg/h (1.6-5.9 lbs/h)
1.0 mm (0.040 in.)	100-300 A	16.5-34.5 V	4.0-14.6 m/min (157-575 in./min)	1.37-5.15 kg/h (3.0-11.4 lbs/h)
1.2 mm (0.047 in.)	100-300 A	15.5-28 V	2.5-9.6 m/min (98-378 in./min)	1.2-4.8 kg/h (2.6-10. lbs/h)