

OK AristoRod 13.16

OK AristoRod 13.16 is a low-alloyed, chromium-molybdenum (1,3% Cr, 0,5% Mo) ER80S-B2, solid wire for GMAW of creep resistant steels like SA-387 Grade 11, A 335 Grade P11 or similar materials. OK AristoRod 13.16 is a high purity wire with a guaranteed Bruscato factor $X < 15$. It is treated with ESAB's unique advanced surface characteristics (ASC) technology, taking MAG welding operations to new levels of performance and all-round efficiency, especially in robotic and mechanised welding. Characteristics features include excellent start properties; trouble free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire.

Specifications

Classifications	EN ISO 21952-A : G Z CrMo1Si EN ISO 21952-B : G 55 M13 1CM SFA/AWS A5.28 : ER80S-B2
Approvals	CE : EN 13479 NAKS/HAKC : 1.2 mm UKCA : EN 13479

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

Alloy Type	Low-alloyed, 1,3Cr-0,5Mo
Shielding Gas	M13, M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO A Ar, 15-25%CO₂ (M21)			
PWHT 1 hour(s) 685 °C	460 MPa	580 MPa	26 %
AWS Ar / 1-3% O₂ (M13)			
PWHT 1 hour(s) 620 °C	540 MPa	640 MPa	26 %
ISO B Ar, 1-3%O₂ (M13)			
PWHT 1 hour(s) 620 °C	530 MPa	610 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO A Ar, 15-25%CO₂ (M21)		
PWHT	20 °C	140 J
AWS Ar / 1-3% O₂ (M13)		
PWHT	20 °C	160 J
PWHT	-20 °C	100 J
ISO B Ar, 1-3%O₂ (M13)		
PWHT	20 °C	160 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.1	0.4	0.5	0.1	1.3	0.5

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	Cu
0.1	0.4	0.5	0.015	0.010	1.3	0.5	0.10

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	80-280 A	18-28 V	2.7-14.7 m/min	1.0-5.4 kg/h

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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	120-350 A	20-33 V	2.7-12.4 m/min	1.5-6.6 kg/h