

## OK Autrod 13.26

A copper coated, low-alloyed, nickel-copper (0,8% Ni, 0,3% Cu), solid wire for GMAW of weathering steels, such as COR-TEN, Patinax, Dillicor etc. The weld metal composition and mechanical properties also make this product suitable for welding high strength steels with a minimum yield strength less than 470 Mpa. OK Autrod 13.26 delivered in the unique Esab Octagonal Marathon Pac is excellent in mechanised welding applications.

### Specifications

#### Classifications

EN ISO 14341-A : G0  
EN ISO 14341-A : G 42 0 C G0  
EN ISO 14341-A : G 46 2 M G0  
SFA/AWS A5.28 : ER80S-G

#### Alloy Type

Low alloyed (0.8 % Ni, 0.4 % Cu)

#### Shielding Gas

M21, C1 (EN 439)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS 80Ar/20CO2 (M21)</b>			
As Welded	540 MPa	625 MPa	26 %
<b>AWS 98Ar/2O2 (M13)</b>			
As Welded	580 MPa	650 MPa	22 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS 80Ar/20CO2 (M21)</b>		
As Welded	-60 °C	50 J
As Welded	20 °C	140 J
As Welded	-46 °C	55 J
As Welded	-20 °C	110 J
As Welded	-40 °C	90 J
<b>AWS 98Ar/2O2 (M13)</b>		
As Welded	-60 °C	30 J
As Welded	-40 °C	70 J
As Welded	-20 °C	100 J
As Welded	20 °C	140 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cu
<b>CO2 (C1)</b>						
0.1	1.3	0.7	0.015	0.010	0.8	0.3
<b>80Ar/20CO2 (M21)</b>						
0.1	1.4	0.8	0.015	0.010	0.8	0.3

### 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