

OK AristoRod 79

The non copper coated OK AristoRod 79 is a low-alloyed, chromium-nickel-molybdenum (0,3% Cr, 1,9% Ni, 0,5% Mo), solid wire for GMAW of high tensile strength steels, heat treated steels and fine grained constructional steels, such as XABO90 with a minimum yield strength less than 850 MPa. The AristoRod wires are suitable for operating at high currents with maintained disturbance free wire feeding giving a stable arc with a low amount of spatter. OK AristoRod 79 delivered in the unique ESAB Octagonal Marathon Pac is excellent in mechanised welding applications.

Specifications

Classifications	EN ISO 16834-A : G 79 4 M20 Mn4Ni2CrMo EN ISO 16834-A : G 79 4 M21 Mn4Ni2CrMo EN ISO 16834-A : G Mn4Ni2CrMo SFA/AWS A5.28 : ER120S-G
Approvals	CE : EN 13479 UKCA : EN 13479

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

Alloy Type	0,3% Cr, 1,9% Ni, 0,5% Mo
Shielding Gas	M20, M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO₂ (M21)			
As Welded	810 MPa	900 MPa	18 %
EN 92Ar/8CO₂ (M20)			
As Welded	825 MPa	900 MPa	17 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
EN 80Ar/20CO₂ (M21)		
As Welded	-40 °C	55 J
As Welded	-20 °C	60 J
As Welded	0 °C	70 J
EN 92Ar/8CO₂ (M20)		
As Welded	-40 °C	75 J
As Welded	-50 °C	65 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.09	1.82	0.89	2.03	0.25	0.64

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Ti
0.1	1.7	0.7	0.01	0.01	1.9	0.3	0.5	0.07	0.03

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
1.2 mm	120-350 A	20-33 V	2.7-12.4 m/min	1.5-6.6 kg/h