

OK AristoRod 38 Zn

The non copper coated OK AristoRod 38 Zn is a manganese-silicon alloyed solid wire for GMAW of galvanised steels with an outstanding performance in terms of low porosity, low spatter and low risk of burnthrough. The electrode can be welded with a gas mixture (M20/M21). OK AristoRod 38 Zn delivered in the unique ESAB Octogonal Marathon Pac is excellent for mechanised 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	540 MPa	29 %
M21 EN ISO			
As Welded	440 MPa	540 MPa	29 %
EN ISO M20			
As Welded	440 MPa	550 MPa	30 %
AWS M20			
As Welded	450 MPa	550 MPa	30 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS M21		
As Welded	-30 °C	120 J
M21 EN ISO		
As Welded	-30 °C	100 J
As Welded	-40 °C	100 J
EN ISO M20		
As Welded	-40 °C	110 J
As Welded	-30 °C	110 J
AWS M20		
As Welded	-30 °C	140 J

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	50-150 A	15-21.5 V	3.2-11.7 m/min	0.72-2.66 kg/h
1.0 mm	100-300 A	16.5-34.5 V	4.0-14.6 m/min	1.37-5.15 kg/h
1.2 mm	100-300 A	15.5-28 V	2.5-9.6 m/min	1.2-4.8 kg/h