OK AristoRod 13.08

The non copper coated OK AristoRod 13.08 is a ER80S-D2 classified, manganese-molybdenum (1,6% Mn, 0,4% Mo), solid wire for GMAW of creep resistant steels of the same type, such as pipes in pressure vessels and boilers with a working temperature of up to 500 C. 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 13.08 delivered in the unique Esab Octagonal Marathon Pac is excellent in mechanised welding applications.

Specifications	
Classifications	EN ISO 14341-A : G 46 0 C1 4Mo EN ISO 14341-A : G 50 4 M21 4Mo EN ISO 14341-A : G 4Mo SFA/AWS A5.28 : ER80S-D2 CAN/CSA-ISO 14341 : B-G 55A 3 C1 S4M31

Alloy Type	Low alloyed (1.6 % Mn, 0.4 % Mo)
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
EN 80Ar/20CO2 (M21)			
As Welded	590 MPa	685 MPa	24 %
AWS CO2 (C1)			
As Welded	540 MPa	645 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
EN 80Ar/20CO2 (M21)		
As Welded	-20 °C	100 J
As Welded	-40 °C	80 J
As Welded	20 °C	140 J
AWS CO2 (C1)		
As Welded	-20 °C	36 J
As Welded	20 °C	90 J
As Welded	-40 °C	38 J

Typical Wire Composition %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.098	1.78	0.6	0.05	0.04	0.47

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Mo**	**Cu**
0.07	1.6	0.5	0.01	0.01	0.05	0.4	0.15

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.0 mm	90-300 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