

OK AristoRod 13.22

The non copper coated OK AristoRod 13.22 is a low-alloyed, chromium-molybdenum (2,6% Cr, 1,1 % Mo), solid wire for GMAW of creep resistant steels of similar composition. For service temperatures up to 600 C. Similar to AWS A5.28 ER80S-B2. 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 13.22 can even be delivered in the unique Esab Octagonal Marathon Pac is excellent in mechanised welding applications.

Specifications

Classifications	EN ISO 21952-A : G CrMo2Si EN ISO 21952-B : G 62 M 2C1M3 SFA/AWS A5.28 : ER90S-G
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Alloy Type	Low alloyed (Cr 2.5% and Mo 1.0%)
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)			
Stress relieved++ 1 hour(s) 700 °C	550 MPa	660 MPa	21 %
Stress relieved+ 0.5 hour(s) 750 °C	410 MPa	520 MPa	24 %
AWS 80Ar/20CO2 (M21)			
As Welded	750 MPa	890 MPa	19 %
As Welded+	680 MPa	880 MPa	19 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
EN 80Ar/20CO2 (M21)		
Stress relieved++	-20 °C	80 J
Stress relieved++	20 °C	130 J
Stress relieved++	-40 °C	45 J
AWS 80Ar/20CO2 (M21)		
As Welded	20 °C	55 J
As Welded	-40 °C	30 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.07	1.0	0.65	0.1	2.45	1.0

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo
0.06	1.0	0.6	0.015	0.010	2.5	1.0

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
1.6 mm	225-480 A	26-38 V	3.1-8.1 m/min	3.3-0.0 kg/h