

OK AristoRod 89

The non copper coated OK AristoRod 89 is a low-alloyed, chromium-nickel-molybdenum (0,4% Cr, 2,2% Ni, 0,55% Mo), solid wire for GMAW of ultra high tensile strength steels requiring tough weld metal for critical applications. Also suitable when high impact strength at lower temperatures is required. 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, due to its unique Advanced Surface Characteristics (ASC) technology. OK AristoRod 89 is delivered on spools or in the unique ESAB Octagonal Marathon Pac, which is excellent in mechanised welding applications. Typical materials according to ISO 15608:2000 and some brand names from steel suppliers are S890QL, Weldom 900, 1100, 1300, Domex 960, XABO 890, 960, 1100, NAXTRA 70, OX-700, 800, 1002, Optim 900QC, 960QC, 1100QC, T1 - HY80.

Specifications

Classifications	EN ISO 16834-A : G Mn4Ni2CrMo SFA/AWS A5.28 : ER120S-G EN ISO 16834-A : G 89 4 M20 Mn4Ni2CrMo EN ISO 16834-A : G 89 4 M21 Mn4Ni2CrMo
Approvals	CE : EN 13479 DB : 42.039.37 DNV : G 89 4 M Mn4Ni2CrMo UKCA : EN 13479 VdTUV : 11881

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

Alloy Type	0,4% Cr, 2,2%Ni, 0,55% Mo
Shielding Gas	M20, M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)			
As Welded	920 MPa	960 MPa	18 %
EN 92Ar/8CO2 (M20)			
As Welded	905 MPa	960 MPa	19 %

Charpy Testing

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

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.081	1.75	0.8	2.22	0.41	0.533

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
0.8 mm	40-170 A	16-22 V	2.0-10.8 m/min	0.4-2.6 kg/h
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