

OK Aristorod 13.26

The non copper coated OK AristoRod 13.26 is a low-alloyed, nickel-copper (0,8% Ni, 0,45% Cu), solid wire for GMAW of weathering steels, such as COR-TEN, Patinax, Dillilcor etc.

According to NACE it would be acceptable to use these welding consumables, since the nickel content is below the maximum acceptable level, 1 % for sour gas applications.

One other requirement from NACE is the maximum hardness of the deposited weld metal, which must not exceed 22 HRC.

The weld metal composition and mechanical properties also make this product suitable for welding high strength steels with a minimum yield strength less than 470 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 13.26 delivered in the unique Esab Octagonal Marathon Pac is excellent in mechanised welding applications.

Classifications Weld Metal	EN ISO 14341 -A : G 42 0 C1 Z 3Ni1Cu EN ISO 14341-A : G 46 4 M21 Z 3Ni1Cu
Classifications Wire Electrode	SFA/AWS A5.28 : ER80S-G EN ISO 14341-A : G Z 3Ni1Cu
Approvals	CE EN 13479 DB 42.039.32 DNV-GL II YMS (C1) DNV-GL III YMS (M21) NAKS/HAKC 1.2MM

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

Alloy Type	Low alloyed (0.8 % Ni, 0.4 % Cu)
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS 80Ar/20CO2 (M21)			
As Welded	540 MPa	625 MPa	26 %
AWS 98Ar/2O2 (M13)			
As Welded	580 MPa	650 MPa	22 %
EN 80Ar/20CO2 (M21)			
As Welded	540 MPa	625 MPa	26 %

Typical Charpy V-Notch Properties

Condition
AWS 80Ar/20CO2 (M21)
As Welded
As Welded
As Welded
As Welded
As Welded
AWS 98Ar/2O2 (M13)
As Welded
As Welded
As Welded
As Welded
EN 80Ar/20CO2 (M21)
As Welded

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cu
0.1	1.3	0.7	0.015	0.010	0.8	0.3

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.095	1.32	0.80	0.84	0.12	0.02	0.30

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Deposition Data

Diameter	Current	Voltage	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
1.4 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