

OK Aristorod 13.26

OK AristoRod 13.26 is a 0.8Ni-0.3Cu-alloyed, bare, solid wire for the GMAW of weathering steels such as COR-TEN, Patinax, Dillicor and so on. It is also suitable for high strength steels with a yield strength of up to 470 MPa.

OK AristoRod 13.26 is treated with ESAB's unique Advanced Surface Characteristics (ASC) technology, taking MAG welding operations to new levels of performance and all-round efficiency, especially in robotic and mechanised welding. Characteristic features include excellent start properties; trouble-free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire.

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	EN ISO 14341 -A: G Z 3Ni1Cu SFA/AWS A5.28: ER80S-G
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)
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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	Testing Temperature	Condition
AWS 80Ar/20CO2 (M21)		
As Welded	20 °C	140 J
As Welded	0 °C	142 J
As Welded	-20 °C	110 J
As Welded	-40 °C	83 J
As Welded	-60 °C	50 J
AWS 98Ar/2O2 (M13)		
As Welded	20 °C	140 J
As Welded	-20 °C	100 J
As Welded	-40 °C	70 J
As Welded	-60 °C	30 J
EN 80Ar/20CO2 (M21)		
As Welded	-60 °C	50 J

Typical Wire Composition %

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

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	80-280 A	18-28 V	1.0-5.4 m/min	1.0-5.4 kg/h
1.0 mm	80-280 A	18-28 V	1.0-5.4 m/min	1.0-5.4 kg/h
1.2 mm	120-350 A	20-33 V	1.5-6.6 m/min	1.5-6.6 kg/h
1.4 mm	120-350 A	20-33 V	1.5-6.6 m/min	1.5-6.6 kg/h
1.6 mm	225-480 A	26-38 V	3.3-0.0 m/min	3.3-0.0 kg/h