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

Alloy Type	Low alloyed (Cr 2.5% and Mo 1.0%)
Shielding Gas	M21 (EN ISO 14175)

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

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
EN 80Ar/20CO2 (M21)		
Stress relieved++ 1 hour(s) 700 °C	20 °C	130 J
Stress relieved++ 1 hour(s) 700 °C	-20 °C	80 J
Stress relieved++ 1 hour(s) 700 °C	-40 °C	45 J
AWS 80Ar/20CO2 (M21)		
As Welded	20 °C	55 J
As Welded	-40 °C	30 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**S**	**P**	**Cr**	**Mo**
80Ar/20CO2 (M21)						
0.06	1.0	0.6	0.015	0.010	2.5	1.0

Typical Wire Composition %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.07	1.0	0.65	0.1	2.45	1.0

Deposition Data				
Diameter	**Amps**	**Volts**	**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