OK AristoRod 79

The non copper coated OK AristoRod 79 is a low-alloyed, chromium-nickel-molybdenum (0,3% Cr, 1,9% Ni, 0,5% Mo), solid wire for GMAW of high tensile strength steels, heat treated steels and fine grained constructional steels, such as XABO90 with a minimum yield strength less than 850 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 79 delivered in the unique ESAB Octagonal Marathon Pac is excellent in mechanised welding applications.

Specifications	
Classifications	EN ISO 16834-A : G 79 4 M20 Mn4Ni2CrMo EN ISO 16834-A : G 79 4 M21 Mn4Ni2CrMo EN ISO 16834-A : G Mn4Ni2CrMo SFA/AWS A5.28 : ER120S-G
Approvals	CE : EN 13479 UKCA : EN 13479

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

Alloy Type	0,3% Cr, 1,9% Ni, 0,5% Mo
Shielding Gas	M20, M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
EN 80Ar/20CO2 (M21)			
As Welded	810 MPa	900 MPa	18 %
EN 92Ar/8CO2 (M20)			
As Welded	825 MPa	900 MPa	17 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
EN 80Ar/20CO2 (M21)		
As Welded	0 °C	70 J
As Welded	-20 °C	60 J
As Welded	-40 °C	55 J
EN 92Ar/8CO2 (M20)		
As Welded	-40 °C	75 J
As Welded	-50 °C	65 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**Ti**
80Ar/20CO2 (M21)									
0.1	1.7	0.7	0.01	0.01	1.9	0.3	0.5	0.07	0.03

Typical Wire Composition %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.09	1.82	0.89	2.03	0.25	0.64

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