OK AristoRod 13.09

OK AristoRod 13.09 is a 0.5Mo-alloyed, bare, solid wire for the GMAW of creep-resistant steels of the same composition, like those used for pipes in pressure vessels and boilers with a service temperature of up to 500°C. OK AristoRod 13.09 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 38 0 C1 2Mo, EN ISO 14341-A:G 46 2 M21 2Mo
Classifications Wire Electrode:	SFA/AWS A5.28:ER80S-G, EN ISO 14341-A:G 2Mo, EN ISO 21952-A:G MoSi, EN ISO 21952-B:G 1M3
Approvals:	CE EN 13479, DNV III YMS (M21), NAKS/HAKC 1.2MM, DB 42.039.31, VdTÜV 10088

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

Alloy Type:	Low alloyed (0.5 % Mo)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
80Ar/20CO2			
As welded	515 MPa	630 MPa	26 %
As welded+	425 MPa	570 MPa	20 %
80Ar/20CO2 Tested at 450°C			
Stress relieved 15 hr 620 °C	430 MPa	545 MPa	26 %
Stress relieved 15 hr 620 °C	370 MPa	490 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
80Ar/20CO2		
As welded	20 °C	117 J
As welded	-20 °C	75 J
As welded	-40 °C	57 J
Stress relieved 15 hr 620 °C	20 °C	150 J
Stress relieved 15 hr 620 °C	0 °C	130 J
Stress relieved 15 hr 620 °C	-20 °C	95 J
Stress relieved 15 hr 620 °C	-40 °C	90 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.094	1.09	0.61	0.04	0.07	0.45