



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK AristoRod 69

Prepared by Mats Linde	Qualified by tolota	Approved by Jose Abal Lopez	Reg no EN007615	Cancelling EN006110	Reg date 2017-09-08	Page 1 (2)
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REASON FOR ISSUE

Chemical data updated.

GENERAL

The non copper coated OK AristoRod 69 is a low-alloyed, chromium-nickel-molybdenum (0,3% Cr, 1,4% Ni, 0,25% Mo), solid wire for GMAW of high tensile strength steels requiring tough weld metal for critical applications. Also suitable when high impact strength at lower temperatures is required.

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 69 delivered in the unique Esab Octagonal Marathon Pac is excellent in mechanised welding applications.

Shielding Gas: M21 (EN ISO 14175)

Alloy Type: Low alloyed (1.4 % Ni, 0.3 % Cr, 0.3 % Mo)

CLASSIFICATIONS Weld Metal (as welded)

EN ISO 16834-A G 69 4 M Mn3Ni1CrMo

CLASSIFICATIONS Wire Electrode

EN ISO 16834-A G Mn3Ni1CrMo
SFA/AWS A5.28 ER110S-G

APPROVALS

ABS ER 110S-G (M21)
CE EN 13479
DB 42.039.33
DNV-GL IV Y69MS (M21)
VdTÜV 11837

APPROVALS (SPECIFIC)

NAKS/HAKC 1.2MM

APPROVAL COMMENT

Approvals valid for lot numbers with prefix in right column.

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
		Min	Max
	80Ar/20CO2 (M21)		
	Nom		
C	0.06		0.12
Si	0.6	0.4	0.7
Mn	1.6	1.5	1.8
P	0.01		0.015
S	0.01		0.015
Cr	0.3	0.20	0.40
Ni	1.4	1.20	1.60
Mo	0.25	0.2	0.3
V	0.07	0.05	0.10
Cu	0.07		0.15



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MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	AWS 80Ar/20CO2 (M21) As welded		EN 80Ar/20CO2 (M21) As welded			EN 80Ar/20CO2 (M21) Stress relieved 620°C 15h	
	Min	Typ	Min	Max	Typ	Typ	
Rp0.2 (MPa)		715	690		730	690	
Rm (MPa)	760	805	770	940	800	750	
A4-A5 (%)		17	17		19	20	
Charpy V at 20°C (J)					100	130	
Charpy V at -20°C (J)						60	
Charpy V at -30°C (J)		80				60	
Charpy V at -40°C (J)		60	47		73		

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W Nom	η Nom	H		Feed			U	
	Min	Max			Min	Max	Min	Max	Min	Max	
\emptyset											
0.8	80	280	15		1	5,4	2,7	14,7	18		28
0.9	80	280	15		1	5,4	2,7	14,7	18		28
1.0	80	280	15		1	5,4	2,7	14,7	18		28
1.2	120	350	18		1,5	6,6	2,7	12,4	20		33
1.6	225	480	22		3,3	0	3,1	8,1	26		38

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)