



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK AristoRod 79

Prepared by Mats Linde	Qualified by skodcz	Approved by Per-Erik Andersson	Reg no EN006368	Cancelling EN005222	Reg date 2014-03-21	Page 1 (2)
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REASON FOR ISSUE

CE approval added

GENERAL

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.

Shielding Gas: M21 (EN ISO 14175)

Alloy Type: 0,3% Cr, 1,9% Ni, 0,5% Mo

CLASSIFICATIONS Weld Metal (as welded)

APPROVALS

EN ISO 16834-A G 79 4 M Mn4Ni2CrMo

CE

EN 13479

CLASSIFICATIONS Wire Electrode

EN ISO 16834-A G Mn4Ni2CrMo

SFA/AWS A5.28 ER120S-G

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
		Min	Max
	80Ar/20CO2 (M21)		
C	0.1	0.08	0.12
Si	0.7	0.60	0.90
Mn	1.7	1.70	2.10
P	0.01		0.015
S	0.01		0.018
Cr	0.3	0.25	0.45
Ni	1.9	1.80	2.30
Mo	0.5	0.45	0.65
Cu	0.07		0.15
Ti	0.03		0.15

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal		
	Min	Max	Typ
	EN 80Ar/20CO2 (M21)		
	As welded		
Rp0.2 (MPa)	790		810
Rm (MPa)	880	1080	900
A4-A5 (%)	16		18
at 0°C (J)			70
at -20°C (J)			60
at -40°C (J)	47		55



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed			U	
	Min	Max			Min	Max	Min	Max	Min	Max	
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	

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)