



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK AristoRod 89

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Per-Erik Andersson	Reg no EN006087	Cancelling EN005606	Reg date 2013-05-23	Page 1 (2)
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REASON FOR ISSUE

Classification update.

GENERAL

The non copper coated OK AristoRod 89 is a low-alloyed, chromium-nickel-molybdenum (0,4% Cr, 2,2% Ni, 0,55% Mo), solid wire for GMAW of ultra 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, due to its unique Advanced Surface Characteristics (ASC) technology.

OK AristoRod 89 is delivered on spools or in the unique ESAB Octagonal Marathon Pac, which is excellent in mechanised welding applications.

Typical materials is according to ISO 15608:2000 and some brand names from steel suppliers are S890QL, Weldom 900,1100,1300,Domex 960,XABO 890,960,1100, NAXTRA 70, OX-700,800,1002, Optim 900QC, 960QC, 1100QC,T1 - HY80.

Shielding Gas: M21 (EN ISO 14175)

Alloy Type: 0,4% Cr, 2,2%Ni, 0,55% Mo

CLASSIFICATIONS Wire

EN ISO 16834-A G Mn4Ni2CrMo
SFA/AWS A5.28 ER120S-G

APPROVALS

CE EN 13479
DB 42.039.37
GL 4Y89S
VdTÜV 11881

CLASSIFICATIONS Weld Metal (as welded)

EN ISO 16834-A G89 4 M Mn4Ni2CrMo

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C	0.08	0.12
Si	0.60	0.90
Mn	1.60	2.10
P		0.015
S		0.015
Cr	0.25	0.45
Ni	2.10	2.30
Mo	0.45	0.65
V		0.03
Cu		0.15
Al		0.03
Ti		0.15
Zr		0.03



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MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

	EN 80Ar/20CO ₂ (M21)		
	As welded		
Properties	Min	Max	Typ
Rp0.2 (MPa)	890		920
Rm (MPa)	940	1100	1000
A4-A5 (%)	16		18
at -40°C (J)	47		53

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H	Feed		U		
	Min	Max				Min	Max	Min	Max	
\emptyset			Nom	Nom	Min	Max	Min	Max	Min	Max
0.8	40	170	12		0,4	2,6	2	10,8	16	22
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)