Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK AristoRod 13.26

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
Mats Linde	Tero Tolonen	Per-Erik Andersson	EN006208	EN005535	2013-09-12	1 (2)

REASON FOR ISSUE

Approvals update.

GENERAL

The non copper coated OK AristoRod 13.26 is a low-alloyed, nickel-copper (0,8% Ni, 0,45% Cu), solid wire for GMAW of weathering steels, such as COR-TEN, Patinax, Dillicor etc.

According to NACE it would be acceptable to use these welding consumables, since the nickel content is below

the maximum acceptable level, 1 % for sour gas applications.

One other requirement from NACE is the maximum hardness of the deposited weld metal, which must not exceed 22 HRC.

The weld metal composition and mechanical properties also make this product suitable for welding high strength steels with a minimum yield strength less than 470 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 13.26 delivered in the unique Esab Octagonal Marathon Pac is excellent in mechanised welding applications.

Shielding Gas: M21, C1 (EN ISO 14175)

Alloy Type: Low alloyed (0.8 % Ni, 0.4 % Cu)

CLASSIFICATIONS Weld Metal

EN ISO 14341-A	G 42 0 C1 Z 3Ni1Cu
EN ISO 14341-A	G 46 4 M21 Z 3Ni1Cu

CLASSIFICATIONS Wire Electrode

EN ISO 14341-A	G Z 3Ni1Cu
SFA/AWS A5.28	ER80S-G

APPROVALS

CE	EN 13479
DB	42.039.32
DNV	II YMS (C1)
DNV	III YMS (M21)

APPROVAL COMMENT

Valid for lotnumbers starting with PV

CHEMICAL COMPOSITION

	All Weld Metal (%)		Wire/Strip (%)	
	80Ar/20CO2 (M21)	CO2 (C1)		
	Nom	**Nom**	**Min**	**Max**
C	0.1	0.1	0.08	0.11
Si	0.8	0.7	0.70	0.90
Mn	1.4	1.3	1.25	1.55
P	0.010	0.010		0.025
S	0.015	0.015		0.025
Ni	0.8	0.8	0.8	0.9
Cu	0.3	0.3	0.25	0.60

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MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

	AWS 80Ar/20CO2 (M21) As welded		AWS 98Ar/2O2 (M13) As welded
Properties	**Min**	**Typ**	**Typ**
Rp0.2 (MPa)		540	580
Rm (MPa)	550	625	650
A4-A5 (%)		26	22
Z (%)		70	60
at 20°C (J)		140	140
at 0°C (J)		142	
at -20°C (J)		110	100
at -40°C (J)		83	70
at -60°C (J)		50	30
	Comments: Interpass temp 170-200°C		Comments: Interpass temp 170-200°C

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
Ø	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
0.8	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
1.4	120	350	18		1,5	6,6	2,7	12,4	20	33
1.6	225	480	20		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)