

OK AristoRod 89

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 in spools or in the unique ESAB Marathon Pac, which is excellent in mechanised welding applications.

Specifications	
Classifications	EN ISO 16834-A : G Mn4Ni2CrMo SFA/AWS A5.28 : ER120S-G EN ISO 16834-A : G 89 4 M Mn4Ni2CrMo
Approvals	CE : EN 13479 DB : 42.039.37 DNV : G 89 4 M Mn4Ni2CrMo UKCA : EN 13479 VdTÜV : 11881

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

Alloy Type	Low alloyed (0.4% Cr, 2.2%Ni, 0.55% Mo)
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Typical Tensile Properties				
Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)				
As Welded	As welded	920 MPa	1000 MPa	18 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
EN 80Ar/20CO2 (M21)		
As Welded	-40 °C	53 J

Typical Wire Composition %					
C	Mn	Si	Ni	Cr	Mo
0.081	1.75	0.80	2.22	0.41	0.53

Deposition Data		
Diameter	Current	Voltage
0.8 mm	40-170 A	16-22 V
1.0 mm	80-280 A	18-28 V
1.2 mm	120-350 A	20-33 V