OK AristoRod 69

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.

Specifications	
Classifications	EN ISO 16834-A : G 69 4 M Mn3Ni1CrMo EN ISO 16834-A : G Mn3Ni1CrMo SFA/AWS A5.28 : ER110S-G
Approvals	ABS : ER110S-G (M21) CE : EN 13479 DB : 42.039.33 DNV-GL : IV Y69MS (M21) VdTÜV : 11837 NAKS/HAKC : 1.2MM

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

Alloy Type	Low alloyed (1.4 % Ni, 0.3 % Cr, 0.3 % Mo)
Shielding Gas	M20, M21 (EN ISO 14175)

Typical Tensile Properties				
Condition	**Conditional Statement**	**Yield Strength**	**Tensile Strength**	**Elongation**
EN 80Ar/20CO2 (M21)				
As Welded	As welded	730 MPa	800 MPa	19 %
Stress Relieved 15 hour(s) 620 °C	Stress relieved	690 MPa	750 MPa	20 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
EN 80Ar/20CO2 (M21)		
Stress Relieved	-20 °C	60 J
Stress Relieved	-30 °C	60 J
Stress Relieved	20 °C	130 J
As Welded	-40 °C	73 J
As Welded	20 °C	100 J

Typical Wire Composition %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.089	1.54	0.53	1.23	0.26	0.24

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Cu**
0.06	1.6	0.6	0.01	0.01	1.4	0.3	0.25	0.07	0.07

Deposition Data		
Diameter	**Current**	**Voltage**
0.8 mm	80-280 A	18-28 V
0.9 mm	80-280 A	18-28 V
1.0 mm	80-280 A	18-28 V
1.2 mm	120-350 A	20-33 V
1.6 mm	225-480 A	26-38 V