

OK AristoRod 13.16

OK AristoRod 13.16 is a low-alloyed, chromium-molybdenum (1,3% Cr, 0,5% Mo) ER80S-B2, solid wire for GMAW of creep resistant steels like SA-387 Grade 11, A335 Grade P11 or similar materials. OK AristoRod 13.16 is a high purity wire with a guaranteed Bruscato factor $X < 15$. It is treated with ESAB's unique Advanced Surface Characteristics (ASC) technology, taking MAG welding operations to new levels of performance and all-round efficiency, especially in robotic and mechanised welding. Characteristics features include excellent start properties; trouble free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire.

Specifications

Classifications	EN ISO 21952-A : G Z CrMo1Si EN ISO 21952-B : G 55 M13 1CM SFA/AWS A5.28 : ER80S-B2
Approvals	CE : EN 13479 NAKS/HAKC : 1.2 mm UKCA : EN 13479

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

Alloy Type	Low alloyed (1.3Cr-0.5Mo)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Ar / 1-3% O2 (M13) AWS			
Stress Relieved 1 hour(s) 620 °C	540 MPa	640 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Ar / 1-3% O2 (M13) AWS		
Stress Relieved	-40 °C	>47 J
Stress Relieved	-20 °C	100 J
Stress Relieved	20 °C	163 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.1	0.4	0.5	0.1	1.3	0.5

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Mo	Cu
0.1	0.4	0.5	0.015	0.010	1.3	0.5	0.10

Deposition Data

Diameter	Current	Voltage
1.0 mm	80-280 A	18-28 V
1.2 mm	120-350 A	20-33 V