

# OK AristoRod 13.09 GMAW

## ER80S-G

### Description

OK AristoRod™ 13.09 is a 0.5Mo-alloyed, bare, solid wire for the GMAW of creep-resistant steels of the same composition, like those used for pipes in pressure vessels and boilers with a service temperature of up to 500°C. OK AristoRod 13.09 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. Characteristic 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.

### Welding current

DC+

### Classifications

SFA/AWS A5.28	ER80S-G
EN 440	G2Mo
EN 12070	G MoSi

### Wire composition

C	Si	Mn	Mo
0.1	0.5	1.1	0.5

### Typical mech. properties all weld metal

Yield stress, MPa	540
Tensile strength, MPa	630
Elongation, %	25

### Charpy V

Test temps, °C	Impact values, J
+20	117
-20	77
-40	57

### Approvals

DB	42.039.31
DNV	III YMS (M21)
DS	EN 12070 (M21)
Ü	42.039/1
VdTÜV	

### Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	2.0-10.8	40-170	16-22	0.4-2.6
1.0	2.7-14.7	80-280	18-28	1.0-5.4
1.2	2.7-12.4	120-350	20-33	1.5-6.6
1.6	3.10-12.0	225-480	26-38	3.3-11.6