

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 Marathon Pac is excellent in mechanised welding applications.

Classifications Weld Metal:	EN ISO 16834-A:G 69 4 M Mn3Ni1CrMo
Classifications Wire Electrode:	EN ISO 16834-A:G Mn3Ni1CrMo, SFA/AWS A5.28:ER110S-G
Approvals:	CE EN 13479, NAKS/HAKC 1.2MM, ABS ER 110S-G (M21), DB 42.039.33, DNV IV Y69MS, GL 4Y69M, VdTÜV 11837

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)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)			
As welded	730 MPa	800 MPa	19 %
Stress relieved 15 hr 620 °C	690 MPa	750 MPa	20 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
EN 80Ar/20CO2 (M21)		
As welded	20 °C	100 J
As welded	-40 °C	73 J
Stress relieved 15 hr 620 °C	20 °C	130 J
Stress relieved 15 hr 620 °C	-20 °C	60 J
Stress relieved 15 hr 620 °C	-30 °C	60 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.089	1.54	0.53	1.23	0.26	0.24

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	80-280 A	18-28 V	2,7-14,7 m/min	1-5,4 kg/h
0.9 mm	80-280 A	18-28 V	2,7-14,7 m/min	1-5,4 kg/h
1.0 mm	80-280 A	18-28 V	2,7-14,7 m/min	1-5,4 kg/h
1.2 mm	120-350 A	20-33 V	2,7-12,4 m/min	1,5-6,6 kg/h
1.6 mm	225-480 A	26-38 V	3,1-8,1 m/min	3,3-0 kg/h