

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

Classifications Weld Metal:	EN ISO 16834-A:G89 4 M Mn4Ni2CrMo
Classifications Wire Electrode:	EN ISO 16834-A:G Mn4Ni2CrMo, SFA/AWS A5.28:ER120S-G
Approvals:	CE EN 13479, DB 42.039.37, GL 4Y89S, VdTÜV 11881

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

Alloy Type:	0,4% Cr, 2,2%Ni, 0,55% Mo
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)			
As welded	920 MPa	940 MPa	18 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
EN 80Ar/20CO2 (M21)		
As welded	-40 °C	47 J

Typical Wire Composition %					
C	Mn	Si	Ni	Cr	Mo
0.081	1.75	0.8	2.22	0.41	0.533

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	40-170 A	16-22 V	2-10,8 m/min	0,4-2,6 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