



Product Data Sheet

OK Aristorod 13.12 A

G 'Gas-shielded metal-arc welding'

Prepared by Henry Zhou	Qualified by Yu Sun	Approved by Leo Liu	Reg No. PDS-2390G-01	Rev. 1	Reg date 2023-10-10	Page 1/1
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REASON FOR ISSUE

The new product.

The non copper coated OK Aristorod 13.12 A is a low-alloyed, chromium-molybdenum (1,1% Cr, 0,5% Mo), solid wire for GMAW of creep resistant steels of similar composition. Suitable for service temperatures up to 450 °C.

The copper free 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 13.12 A delivered in the unique ESAB Octagonal Marathon Pac is excellent in mechanised welding applications.

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.28 ER80S-B2Si
 EN ISO 21952-A G CrMo1Si

Approvals

Not applicable

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.08	0.12
Si	0.50	0.80
Mn	0.80	1.20
P		0.015
S		0.015
Cr	1.00	1.30
Ni		0.15
Mo	0.45	0.65
Cu		0.15

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Standard	Shielding Gas	Condition	Rp0.2 MPa		Rm MPa			A5 %		Charpy V J/20°C	
			Min	Typ	Min	Max	Typ	Min	Typ	Min	Typ
EN	80Ar/20CO2 (M21)	As Weld 690°C, 1h	470	610 500	550		720 610	20	18 24	47	80 110

Deposit rate				
Diameter	Current	Voltage	Feeding Speed	Deposit rate
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