

## OK Aristorod 13.08

OK AristoRod 13.08 is a 0.4Mo-alloyed (ER80S-D2), bare, solid wire for the GMAW of creep-resistant steels of the same composition, like those used with a service temperature of up to 500°C. OK AristoRod 13.08 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.

<b>Clasificaciones metal de soldadura</b>	EN ISO 14341-A : G 46 0 C1 4Mo EN ISO 14341-A : G 50 4 M21 4Mo
<b>Clasificaciones electrodo de hilo</b>	SFA/AWS A5.28 : ER80S-D2 EN ISO 14341-A : G 4Mo CAN/CSA-ISO 14341 : B-G 55A 3 C1 S4M31

<b>Tipo de aleación</b>	Low alloyed (1.6 % Mn, 0.4 % Mo)
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### Propiedades tensoras típicas

Condición	Límite de elasticidad	Resistencia a la tracción	Alargamiento
<b>AWS CO2 (C1)</b>			
As Welded	540 MPa	645 MPa	25 %
<b>EN 80Ar/20CO2 (M21)</b>			
As Welded	590 MPa	685 MPa	24 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS CO2 (C1)</b>		
As Welded	20 °C	90 J
As Welded	-20 °C	36 J
As Welded	-40 °C	38 J
<b>EN 80Ar/20CO2 (M21)</b>		
As Welded	20 °C	140 J
As Welded	-20 °C	100 J
As Welded	-40 °C	80 J

### à% Análisis metal depositado (valores típicos)

C	Mn	Si	S	P	Ni	Mo	Cu
0.07	1.6	0.5	0.01	0.01	2	0.4	0.15

### à% Composición hilo (valores típicos)

C	Mn	Si	Ni	Cr	Mo
0.098	1.78	0.6	0.05	0.04	0.47

### Datos aportación

Diámetro	Amperios	Voltios	Velocidad de alimentación de hilo	Tasa de Deposición
0.8 mm	40-170 A	16-22 V	2.0-10.8 m/min	0.4-2.6 kg/h
0.9 mm	70-280 A	18-28 V	2.7-14.7 m/min	1.0-5.4 kg/h
1.0 mm	90-300 A	18-28 V	2.7-14.7 m/min	1.0-5.4 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	3.1-12.0 m/min	3.3-11.6 kg/h