

OK Aristorod 13.09

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.

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|---|---|
| Clasificaciones metal de soldadura | EN ISO 14341-A : G 38 0 C1 2Mo EN ISO 14341-A : G 46 2 M21 2Mo |
| Clasificaciones electrodo de hilo | SFA/AWS A5.28 : ER70S-A1 (ER80S-G) EN ISO 14341-A : G 2Mo EN ISO 21952-A : G MoSi EN ISO 21952-B : G 1M3 |
| Aprobaciones | CE EN 13479 DB 42.039.31 DNV-GL III YMS (M21) NAKS/HAKC 1.2MM VdTUV 10088 |

Las aprobaciones dependen de la ubicación de la fábrica. Póngase en contacto con ESAB para obtener más información.

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|-------------------------|------------------------|
| Tipo de aleación | Low alloyed (0.5 % Mo) |
|-------------------------|------------------------|

Propiedades tensoras típicas

| Condición | Límite de elasticidad | Resistencia a la tracción | Alargamiento |
|----------------------------|-----------------------|---------------------------|--------------|
| 80Ar/20CO2 | | | |
| As Welded | 515 MPa | 630 MPa | 26 % |
| Stress Relieved 15hr 620°C | 370 MPa | 490 MPa | 23 % |
| Stress Relieved 15hr 620°C | 430 MPa | 545 MPa | 26 % |
| As Welded | 425 MPa | 570 MPa | 20 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|----------------------------|---------------------|--------------|
| 80Ar/20CO2 | | |
| As Welded | 20 °C | 117 J |
| As Welded | -20 °C | 75 J |
| As Welded | -40 °C | 57 J |
| Stress Relieved 15hr 620°C | 20 °C | 150 J |
| Stress Relieved 15hr 620°C | 0 °C | 130 J |
| Stress Relieved 15hr 620°C | -20 °C | 95 J |
| Stress Relieved 15hr 620°C | -40 °C | 90 J |

à% Análisis metal depositado (valores típicos)

| C | Mn | Si | S | P | Mo |
|------|-----|------|-------|-------|------|
| 0.09 | 1.0 | 0.65 | 0.015 | 0.010 | 0.45 |

à% Composición hilo (valores típicos)

| C | Mn | Si | Ni | Cr | Mo |
|-------|------|------|------|------|------|
| 0.094 | 1.09 | 0.61 | 0.04 | 0.07 | 0.45 |

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 |
| 1.0 mm | 80-280 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 |