OK AristoRod 13.22 GMAW

ER90S-G

Description

The non copper coated OK AristoRod 13.22 is a low alloyed, chromium-molybdenum (2.6% Cr, 1.1% Mo) solid wire for GMAW of creep resistant steels of similar composition for service temperatures up to 600°C. OK AristoRod 13.22 is treated with ESAB's unique advanced surfaced characteristics (ASC) technology, taking MAG welding operations to new levels of performance and all round efficiency, especially in robotic and mechanised welding. 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 13.22 delivered in the unique ESAB Octagonal Marathon Pac is excellent for mechanised welding applications. The mechanical properties quoted here are welded with 80Ar/20CO_2.

Welding current

DC (+)

Classifications

SFA/AWS A5.28	ER90S-G
EN 12070	G CrMo2Si

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.06	0.6	1.0	2.5	1.0

Typical properties of all weld metal

Yield stress, Mpa	750
Tensile strength, MPa	890
Elongation, %	19

Charpy V

Test temps, °C	Impact values, J
+20	55
-40	30

Welding Parameters

Diameter mm	Wire feed m/min	Welding Current A	Arc Voltage	Deposition rate (kg weld metal/hour arc time)
1,0	2,7-14,7	80-280	18-28	1,0-5,4
1.2	2,7-12,4	120-350	20-33	1,5-6,6
1,6	3,1-8,1	225-480	26-38	3,3-11,6

Packing/Ordering Information

Part Number	Dia mm	Carton Weight (kg)	Pallet Weight (kg)
1B2210771F	1.0	18	1008
1B2212771F	1.2	18	1008
1B2216771F	1.6	18	1008
Marathon Pac			
1B2212932F	1.2	250	1000
1B2216940F	1.6	475	950