

## 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 Octagonal Marathon Pac, which is excellent in mechanised welding applications.

Typical materials is according to ISO 15608:2000 and some brand names from steel suppliers are S890QL, Weldox 900,1100,1300,Domex 960,XABO 890,960,1100, NAXTRA 70, OX-700,800,1002, Optim 900QC, 960QC, 1100QC,T1 - HY80.

<b>Classifications</b>	SFA/AWS A5.28 : ER120S-G EN ISO 16834-A : G Mn4Ni2CrMo EN ISO 16834-A : G89 4 M Mn4Ni2CrMo
<b>Approvals</b>	CE EN 13479 DB 42.039.37 DNV-GL IV Y89MS (M21) VdTÜV 11881

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

<b>Alloy Type</b>	0,4% Cr, 2,2%Ni, 0,55% Mo
<b>Shielding Gas</b>	M21 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>EN 80Ar/20CO2 (M21)</b>			
As Welded	920 MPa	940 MPa	18 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>EN 80Ar/20CO2 (M21)</b>		
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	2.0-10.8 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