OK AristoRod 13.29 GMAW

ER100S-G

Description

OK AristoRod™13.29 is a 0.3Cr-1.4Ni-0.25Mo-alloyed, bare, solid wire for the GMAW of high strength steels with low-temperature impact toughness requirements. OK AristoRod 13.29 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.

Welding current

Classifications

SFA/AWS A5.28	ER100S-G
EN 12534	G Mn3Ni1CrMo

Wire composition

C	Si	Mn	Cr	Ni	Mo
<0.1	0.5	1.6	0.3	1.4	0.2

Typical mech. properties all weld metal

Yield stress, MPa	700
Tensile strength, MPa	800
Elongation, %	19

Charpy V

Test temps, °C	Impact values, J
+20	100
-20	70
-30	60

Approvals

DB	42.039.33
Ü	42.039/5
VdTÜV	

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
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