OK AristoRod 13.12 GMAW

ER80S-G

Description

OK AristoRod™ 13.12 is a 1.1Cr-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 450°C. OK AristoRod 13.12 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

DC+

Classifications

SFA/AWS A5.28	ER80S-G
EN 12070	G CrMo1Si
GOST 2246	08X CM A

Wire composition

C	Si	Mn	Cr	Mo
0.1	0.7	1.0	1.2	0.5

Typical mech. properties all weld metal

Yield stress, MPa	450
Tensile strength, MPa	580
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
+20	80
0	40
-20	30

Approvals

VdTÜV

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	2.0-10.8	40-170	16-22	0.4 -2.6
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	3.1-12.0	225-480	26-38	3.3-11.6