

# OK AristoRod 13.13 GMAW

## ER100S-G

### Description

OK AristoRod™ 13.13 is a 0.5Cr-0.5Ni-0.2Mo-alloyed, bare, solid wire for the GMAW of high strength steels. OK AristoRod 13.13 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	ER100S-G
EN 12534	G Mn3NiCrMo

### Wire composition

C	Si	Mn	Cr	Ni	Mo
0.1	0.7	1.6	0.6	0.6	0.2

### Typical mech. properties all weld metal

Yield stress, MPa	690
Tensile strength, MPa	770
Elongation, %	20

### Charpy V

Test temps, Impact		Test temps, Impact	
°C	values, J	°C	values, J
0	80	-40	60
-20	75		
-30	65		

### 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	3.5-12.0	225-480	26-38	3.3-11.6