



OK Aristorod 13.16

OK AristoRod 13.16 is a low-alloyed, chromium-molybdenum (1,3% Cr, 0,5% Mo) ER80S-B2, solid wire for GMAW of creep resistant steels like SA-387 Grade 11, A 335 Grade P11 or similar materials. OK AristoRod 13.16 is a high purity wire with a guaranteed Bruscato factor X<15. It 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. Characteristics 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.

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| Классификации | AWS A5.28 : ER80S-B2 EN ISO 21952-A : G ZCrMo1Si (приблизительно) EN ISO 21952-B : G 55 M13 1CM3 |
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| Тип сплава | Low-alloyed, 1,3Cr-0,5Mo |
| Защитный газ | M13, M21 (EN ISO 14175) |

Механические свойства при растяжении

| Состояние | Предел текучести | Предел прочности при растяжении | Удлинение |
|----------------------------------|------------------|---------------------------------|-----------|
| AWS Ar / 1-3% O2 (M13) | | | |
| PWHT 1hr 620°C | 540 MPa | 640 MPa | 26 % |
| ISO A Ar, 15-25%CO2 (M21) | | | |
| PWHT 1hr 685°C | 460 MPa | 580 MPa | 26 % |
| ISO B Ar, 1-3%O2 (M13) | | | |
| PWHT 1hr 620°C | 530 MPa | 610 MPa | 23 % |

Типичные свойства образца с V-образным надрезом по Шарпи

| Состояние | Температура испытания | Работа удара |
|--|-----------------------|--------------|
| M21 (80%Ar + 20%CO2)После термообработки | 675-700°C, 1 час | |

Хим. состав наплавленного металла

| C | Mn | Si | S | P | Cr | Mo | Cu |
|-----|-----|-----|-------|-------|-----|-----|------|
| 0.1 | 0.4 | 0.5 | 0.015 | 0.010 | 1.3 | 0.5 | 0.10 |

Хим. состав проволоки

| C | Mn | Si | Ni | Cr | Mo |
|-----|-----|-----|-----|-----|-----|
| 0.1 | 0.4 | 0.5 | 0.1 | 1.3 | 0.5 |

Данные наплавки

| Диаметр | Ток | В | Скорость подачи проволоки | Коефф. наплавки |
|---------|-----------|---------|---------------------------|-----------------|
| 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 |