



# Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK AristoRod 42 LSW

Prepared by Christoffer Svensson	Qualified by P-O Oskarsson	Approved by Raj Kumar Singh	Reg no EN011993	Cancelling None	Reg date 2025-09-17	Page 1 (2)
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## REASON FOR ISSUE

New Product

## GENERAL

A non copper coated solid wire, with an engineered chemistry designed to create minimal slag and silica islands on the weld bead. OK AristoRod 42 LSW is surface treated with ESAB's unique ASC method, a completely new coating technology, which brings MAG welding to new levels in terms of execution and versatile performance, especially in robotic and automated welding.

**Shielding Gas:** M20, M21 (EN ISO 14175)

### CLASSIFICATIONS Weld Metal

EN ISO 14341-A	G 42 3 M20 Z
EN ISO 14341-A	G 42 3 M21 Z
AWS A5.18	ER70S-9
EN ISO 14341-B	G 49A 5 M20 SZ

### APPROVALS

Not applicable

### CLASSIFICATIONS Wire Electrode

EN ISO 14341-A	G Z
AWS A5.18	ER70S-9
EN ISO 14341-B	SZ

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Min	Max	Nom
C	0.05	0.12	0.08
Si		0.09	0.07
Mn	1.3	2.1	1.6
P		0.025	0.01
S		0.035	0.005
Cr		0.15	
Ni		0.50	
Mo		0.15	
V		0.03	
Cu		0.50	
Ti+Zr	0.05	0.20	

## MECHANICAL PROPERTIES OF WELD METAL

### All Weld Metal

Standard	Shielding Gas	Condition	Rp0.2 [MPa/ksi]		ReL [MPa/ksi]		Rm [MPa/ksi]			A4 [%]		A5 [%]	
			Min	Typ	Min	Typ	Min	Max	Typ	Min	Typ	Min	Typ
EN ISO	M20	As welded			420/61	470/68	500/73	640/93	555/80			20	23
AWS	M20	As welded	400/58	460/67			490/71		550/80	22	28		

Comments:





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## MECHANICAL PROPERTIES OF WELD METAL

Standard	Shielding Gas	Condition	Temp [°C/°F]	Charpy V [J/ft-lb]	
				Min	Typ
EN ISO	M20	As welded	-30/-22 -50/-58	47/35 27/20	160/118 130/96
AWS	M20	As welded	-30/-22 -50/-58	27/20	125/93

Comments:

