

OK AristoRod 12.50

GMAW
ER70S-6

Description

OK AristoRod™ 12.50 is a bare Mn-Si-alloyed G3Si1/ER70S-6 solid wire for the GMAW of non-alloyed steels, as used in general construction, automotive components, pressure vessel fabrication and shipbuilding. OK AristoRod 12.50 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 A5.18 | ER70S-6 |
| EN 440 | G3Si1 |

Wire composition

| C | Si | Mn |
|-----|-----|-----|
| 0.1 | 0.9 | 1.5 |

Typical mech. properties all weld metal

| | |
|-----------------------|-----|
| Yield stress, MPa | 470 |
| Tensile strength, MPa | 560 |
| Elongation, % | 26 |

Charpy V

| Test temps, °C | Impact values, J |
|----------------|------------------|
| +20 | 130 |
| -20 | 90 |
| -30 | 70 |

Approvals

| | |
|-------|-----------|
| ABS | 3SA, 3YSA |
| BV | SA3YM |
| CWB | CSA W48 |
| DB | 42.039.29 |
| DNV | III YMS |
| DS | EN 440 |
| GL | 3YS |
| LR | 3S, 3YS |
| Ü | 42.039/1 |
| VdTÜV | |

Welding parameters

| Diameter, mm | Wire feed, m/min | Welding current, A | Arc voltage, V | Deposition rate kg weld metal/hour |
|--------------|------------------|--------------------|----------------|------------------------------------|
| 0.8 | 3.2-10 | 60-200 | 18-24 | 0.8-2.5 |
| 0.9 | 3.0-12 | 70-250 | 18-26 | 0.8-3.3 |
| 1.0 | 2.7-15 | 80-300 | 18-32 | 1.0-5.5 |
| 1.4 | 2.3-12 | 150-420 | 22-36 | 1.6-8.7 |
| 1.6 | 2.3-15 | 225-550 | 28-38 | 2.1-11.4 |

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