

## OK Aristorod 12.65

The non copper coated OK AristoRod 12.65 is a solid wire especially designed for downhill circumferential GMAW on pipes in materials such as API 5L (grade 52 up to grade 70). The main applications are pipelines, compressor stations and associated works in the oil and gas distribution industries with special requirements. To meet these requirements the electrode is a "clean" type of EN 14341-A G4Si1 as regards chemical analysis. The AristoRod wires are suitable for operating at high currents with maintained disturbance free wire feeding giving a stable arc with a low amount of spatter.

### Specifications

<b>Classifications</b>	EN ISO 14341-A : G 42 2 C1 4Si1 EN ISO 14341-A : G 46 3 M21 4Si1 EN ISO 14341-A : G 4Si1 SFA/AWS A5.18 : ER70S-6
<b>Alloy Type</b>	Carbon-manganese steel (Mn/Si-alloyed)
<b>Shielding Gas</b>	M12, M21 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>EN 80Ar/20CO2 (M21)</b>			
As Welded	545 MPa	600 MPa	26 %
<b>EN CO2 (C1)</b>			
As Welded	495 MPa	575 MPa	25 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>EN 80Ar/20CO2 (M21)</b>		
As Welded	-20 °C	100 J
As Welded	20 °C	140 J
As Welded	-30 °C	80 J
<b>EN CO2 (C1)</b>		
As Welded	20 °C	120 J
As Welded	-20 °C	80 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cu
<b>CO2 (C1)</b>					
0.06	1.05	0.72	0.009	0.009	0.02
<b>80Ar/20CO2 (M21)</b>					
0.07	1.25	0.82	0.009	0.009	0.02