

OK AristoRod 12.62

The Triple desoxidized non copper coated OK AristoRod 12.62 is a wire electrode designed for GMAW of mild and fine grained structural- and pressure vessel steels as well as ship building steels and Onshore-Offshore applications. The wire electrode is capable of producing high quality welds in semi-killed and rimmed steel as well as steel of various carbon levels. Because of added desoxidants, Al-Ti-Zr, the wire electrode can also be used for welding steels with a rusty or dirty surface, without any sacrifice of weld quality. The less fluid weld puddle of OK AristoRod 12.62 makes it easy to control when used out of position. OK AristoRod 12.62 is the preferred wire for all position welding of small diameter pipe.

Specifications

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

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)			
As Welded	570 MPa	625 MPa	26 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
EN 80Ar/20CO2 (M21)		
As Welded	-40 °C	180 J

Typical Wire Composition %

C	Mn	Si
0.06	1.1	0.60

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.05	0.72	0.46	0.010	0.010

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
0.8 mm	60-200 A	18-24 V	3.2-10.0 m/min	0.8-2.5 kg/h
0.9 mm	70-250 A	18-26 V	3.0-12.0 m/min	0.8-3.3 kg/h
1.0 mm	80-300 A	18-32 V	2.7-15.0 m/min	1.0-5.5 kg/h
1.2 mm	120-380 A	18-35 V	2.5-15.0 m/min	1.3-8.0 kg/h
1.6 mm	225-550 A	28-38 V	2.3-10.0 m/min	2.1-9.4 kg/h