

OK AristoRod 12.62

OK AristoRod 12.62 is a bare triple deoxidised ER70S-2 solid wire for the GMAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding. It yields high-quality welds in semi-killed and rimmed steels, as well as with grades with various carbon contents. Added deoxidants, Al - Ti- Zr, make the wire also suitable for steels with a dirty or rusty surface, without sacrificing weld quality. OK AristoRod 12.62 is treated with ESAB's unique Advanced Surface Characteristics (ASC) technology, taking MIG/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.

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)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)			
As Welded	570 MPa (83 ksi)	625 MPa (91 ksi)	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
80% Ar - 20% CO2		
As Welded	-40 °C (-40 °F)	180 J (133 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.06	1.1	0.60	0.009	0.008	0.03	0.12	0.01	0.01	0.12

Typical Wire Composition %

Cu	Ti+Zr
0.05	0.13

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (.045 in.)	120-380 A	18-35 V	2.5-15.0 m/min (98-590.5 in./min)	1.3-8.0 kg/h (2.9-17.6 lbs/h)
0.9 mm (.035 in.)	70-250 A	18-26 V	3.0-12.0 m/min (118-472 in./min)	0.8-3.3 kg/h (1.8-7.3 lbs/h)