

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