

OK AristoRod 12.50

OK Aristorod 12.50 is a non copper coated 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.

Specifications	
Classifications	EN ISO 14341-A : G 38 3 C1 3Si1 EN ISO 14341-A : G 42 4 M20 3Si1 EN ISO 14341-A : G 42 4 M21 3Si1 EN ISO 14341-A : G 3Si1 SFA/AWS A5.18 : ER70S-6 CSA W48 : B-G 49A 3 C1 S6 JIS Z 3312 : YGW 12 (C1)
Approvals	ABS : 3Y SA BV : SA3YM CE : EN 13479 DB : 42.039.29 DNV-GL : III YMS LR : 3YS H15 PRS : 3YS RS : 3Y40MS VdTÜV : 10052 CWB : B-G 49A 3 C1 S6 (B-G 49A 3 C G6) JIS : YGW12 (C1) NAKS/HAKC : 1.2-1.6 mm RINA : 3Y S

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Mn-Si alloyed
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
EN 80Ar/20CO2 (M21)			
As Welded	470 MPa	560 MPa	26 %
EN CO2 (C1)			
As Welded	440 MPa	540 MPa	25 %
EN 80Ar/20CO2 (M21)			
Stress Relieved	370 MPa	495 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
EN 80Ar/20CO2 (M21)		
As Welded	-40 °C	90 J
As Welded	-30 °C	100 J
EN CO2 (C1)		
As Welded	-30 °C	75 J
EN 80Ar/20CO2 (M21)		
As Welded	-20 °C	120 J
Stress Relieved	-20 °C	90 J
As Welded	-50 °C	70 J

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Typical Wire Composition %

C	Mn	Si
0.08	1.46	0.85

Deposition Data

Diameter	Current	Voltage
0.8 mm	60-200 A	18-24 V
0.9 mm	70-250 A	18-26 V
1.0 mm	80-300 A	18-32 V
1.2 mm	120-380 A	18-35 V
1.4 mm	150-420 A	22-36 V
1.6 mm	225-550 A	28-38 V
2.0 mm	300-650 A	32-44 V