

## OK Aristorod 12.50

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.

<b>Metallo saldato - Classificazioni</b>	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
<b>Elettrodo filo - Classificazioni</b>	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)
<b>Approvazioni</b>	ABS 3Y SA CWB B-G 49A 3 C1 S6

Le approvazioni si basano sulla localizzazione della fabbrica. Contatta ESAB per maggiori informazioni.

<b>Tipo di lega</b>	Carbon-manganese steel (Mn/Si-alloyed)
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### Proprietà tensili tipiche

Stato	Resistenza allo snervamento	Resistenza alla trazione	Allungamento
<b>AWS CO2 (C1)</b>			
Come saldato	430 MPa	530 MPa	30 %
<b>EN 80Ar/20CO2 (M21)</b>			
Come saldato	470 MPa	560 MPa	26 %
Stress Relieved 15hr 620°C	370 MPa	495 MPa	28 %
<b>EN CO2 (C1)</b>			
Come saldato	440 MPa	540 MPa	25 %

### Typical Weld Metal Analysis %

<b>Ti+Zr</b>	<0,01
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### Wire Composition

<b>C</b>	<b>Mn</b>	<b>Si</b>
0.08	1.46	0.85

### Dati deposito

Diametro	Amp	Volt	Velocità di trascinamento del filo	Tasso di deposito
0.8 mm	60-200 A	18-24 V	0.8-2.3 m/min	0.8-2.3 kg/h
0.9 mm	70-250 A	18-26 V	0.9-3.5 m/min	0.9-3.5 kg/h
1.0 mm	80-300 A	18-32 V	1.0-5.5 m/min	1.0-5.5 kg/h
1.14 mm	100-350 A	18-34 V	1.2-7.0 m/min	1.2-7.0 kg/h
1.2 mm	120-380 A	18-35 V	1.3-8.0 m/min	1.3-8.0 kg/h
1.32 mm	130-400 A	19-35 V	1.5-8.5 m/min	1.5-8.5 kg/h
1.4 mm	150-420 A	22-36 V	1.6-8.7 m/min	1.6-8.7 kg/h
1.6 mm	225-550 A	28-38 V	2.1-9.4 m/min	2.1-9.4 kg/h
2.0 mm	300-650 A	32-44 V	4.4-10.2 m/min	4.4-10.2 kg/h