

## 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.

<b>Classifications Weld Metal</b>	EN ISO 14341-A : G 42 3 C1 2Ti EN ISO 14341-A : G 46 4 M21 2Ti
<b>Classifications Wire Electrode</b>	SFA/AWS A5.18 : ER70S-2 EN ISO 14341-A : G 2Ti

<b>Alloy Type</b>	Carbon-manganese steel (Mn/Si-alloyed)
<b>Shielding Gas</b>	80Ar/20CO <sub>2</sub> , CO <sub>2</sub>

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>EN 80Ar/20CO<sub>2</sub> (M21)</b>			
As Welded	570 MPa (83 ksi)	625 MPa (91 ksi)	26 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>80% Ar - 20% CO<sub>2</sub></b>		

### 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
0.8 mm (0.030 in.)	60-200 A	18-24 V	3.2-10.0 m/min (126-394 in./min)	0.8-2.5 kg/h (1.8-5.5 lb/h)
0.9 mm (0.035 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 lb/h)
1.0 mm (0.040 in.)	80-300 A	18-32 V	2.7-15.0 m/min (106-591 in./min)	1.0-5.5 kg/h (2.2-12. lb/h)
1.2 mm (0.047 in.)	120-380 A	18-35 V	2.5-15.0 m/min (98-591 in./min)	1.3-8.0 kg/h (2.9-17. lb/h)
1.6 mm (1/16 in.)	225-550 A	28-38 V	2.3-10.0 m/min (91-394 in./min)	2.1-9.4 kg/h (4.6-20. lb/h)