

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.

Classificatie lasmetaal	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
Classificatie draadelektrode	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)
Goedkeuringen	ABS 3Y SA BV SA3YM CE EN 13479 DB 42.039.29 DNV-GL III YMS LR 3YS H15 PRS 3YS RS 3Y40MS VdTUV 10052 CWB B-G 49A 3 C1 S6 (B-G 49A 3 C G6) JIS YGW12 (C1) NAKS/HAKC 1.0-1.6 mm NAKS/HAKC 1.2-1.6 mm RINA 3Y S RINA 3Y S

Goedkeuringen zijn gebaseerd op fabriekslocatie. Contacteer ESAB voor meer informatie.

Legering Type	Carbon-manganees steel (Mn/Si-alloyed)
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Typische trekeigenschappen

Conditionering	Rekgrens	Treksterkte	Verlenging
AWS CO2 (C1)			
zoals gelast	430 MPa	530 MPa	30 %
EN 80Ar/20CO2 (M21)			
zoals gelast	470 MPa	560 MPa	26 %
Stress verlicht °C	370 MPa	495 MPa	28 %
EN CO2 (C1)			
zoals gelast	440 MPa	540 MPa	25 %

Kerfslageigenschappen

Conditionering	Testtemperatuur	Kerfslagwaarde
AWS CO2 (C1)		
zoals gelast	-30 °C	75 J
EN 80Ar/20CO2 (M21)		
zoals gelast	20 °C	130 J
zoals gelast	-20 °C	120 J
zoals gelast	-30 °C	100 J
zoals gelast	-40 °C	90 J
zoals gelast	-50 °C	70 J
Stress verlicht	20 °C	120 J
Stress verlicht	-20 °C	90 J
EN CO2 (C1)		
zoals gelast	20 °C	110 J
zoals gelast	-30 °C	75 J

lasmetaal-analyse

Ti+Zr	<0,01
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draad samenstelling

C	Mn	Si
0.08	1.46	0.85

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Afzetgegevens

Diameter	Ampère	Volt	Draadaanvoersnelheid	Afzetwaarde
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