



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK AristoRod 12.62

Prepared by Mats Linde	Qualified by Christos Skodras	Approved by Per-Erik Andersson	Reg no EN005568	Cancelling EN003253	Reg date 2011-10-11	Page 1 (2)
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REASON FOR ISSUE

Shielding Gas N21 added to classification.

GENERAL

The Tripple desoxidized non copper coated OK AristoRod 12.62 is a wire electrode designed for GMAW of mild and fine grained structural- and pressure vessel steels as well as ship building steels. The wire electrode is capable of producing high quality welds in semi-killed and rimmed steel as well as steel of various carbon levels.

Because of added desoxidants, Al-Ti-Zr, the wire electrode can also be used for welding steels with a rusty or dirty surface, without any sacrifice of weld quality.

Shielding Gas: 80Ar/20CO₂, CO₂

Alloy Type: Carbon-manganese steel (Mn/Si-alloyed)

CLASSIFICATIONS Weld Metal

EN ISO 14341-A G 42 3 C1 2Ti
EN ISO 14341-A G 46 4 M21 2Ti

APPROVALS

Not applicable

CLASSIFICATIONS Wire Electrode

EN ISO 14341-A G 2Ti
SFA/AWS A5.18 ER70S-2

CHEMICAL COMPOSITION

	All Weld Metal (%)		Wire/Strip (%)	
	CO ₂ (C1)	80Ar/20CO ₂ (M21)	Min	Max
C	0.05	0.07	0.04	0.07
Si	0.46	0.51	0.40	0.70
Mn	0.72	0.85	0.90	1.40
P	0.010	0.010		0.025
S	0.010	0.010		0.025
Cr				0.15
Ni				0.15
Mo				0.15
V				0.03
Cu				0.15
Al			0.05	0.15
Ti			0.05	0.15
Zr			0.02	0.12
Ti+Zr			0.07	0.25



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MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal					
	AWS CO2 (C1)		EN CO2 (C1)		EN 80Ar/20CO2 (M21)	
	As welded		As welded		As welded	
	Min	Max	Min	Max	Typ	
Rp0.2 (MPa)	400		420		460	570
Rm (MPa)	480		500	640	530	625
A4 (%)	22					
A5 (%)			20		20	26
Charpy V at -29°C (J)	27					
Charpy V at -30°C (J)			47			
Charpy V at -40°C (J)					47	180

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed			U	
	Min	Max			Nom	Nom	Min	Max	Min	Max	Min
\emptyset											
0.8	60	200	14	95	0.8	2.5	3.2	10.0	18		24
0.9	70	250	15	96	0.8	3.3	3.0	12.0	18		26
1.0	80	300	16	96	1.0	5.5	2.7	15.0	18		32
1.2	120	380	18	97	1.3	8.0	2.5	15.0	18		35
1.6	225	550	20	98	2.1	11.4	2.3	15.0	28		38

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)