



ESAB MW1

A Cu coated solid wire for GMAW

Classification AWS A5.18: ER70S-6
EN ISO 14341-A: G 3Si1

DESCRIPTION

ESAB MW1 is a copper coated, Mn-Si alloyed solid wire for GMAW of non alloyed steels, used in general construction, automotives, ship building and pressure vessel fabrication. The wire has a carefully controlled wire chemistry and a unique surface technology providing superior weld metal quality at high wire feed speeds and at high welding currents.

WELDING CURRENT: DC+

APPROVALS: ABS, DNV, IBR, IRS, LRS, MMD, MN Dastur & NPC

SHIELDING GAS: 100%CO₂ or 80%Ar/20%CO₂

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.08	YS (N/mm ²)	450
Si	0.85	UTS (N/mm ²)	560
Mn	1.45	Elongation (%)	24
Cu	0.25	Impact (CVN) @ -30°C (Joules)	50

CURRENT RANGE & PACKING DATA

Size (mm)	Current (Amp)	Voltage (V)	Packing in Kg.				
			12.5	15.0	17.5	100	250
0.8	60-220	17-25	✓	✓	×	✓	×
1.2	90-330	18-30	×	✓	✓	✓	✓
1.6	120-440	20-36	✓	×	×	×	✓
2.0	150-550	21-41	✓	×	×	×	×

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 12.5/15.0/17.5 kg or Marathon Pac weighing 100/250 kg or Bobbins weighing 200 kg.

OK ARISTOROD 12.50

A non Cu coated solid wire for GMAW

Classification AWS A5.18: ER70S-6
EN ISO 14341-A: G 3Si1

DESCRIPTION

OK ARISTOROD 12.50 is a non copper coated Mn-Si alloyed solid wire for the GMAW of unalloyed steels, 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. OK ARISTOROD 12.50 is available in the unique ESAB octagonal Marathon Pac, which is excellent for mechanised welding applications.

APPROVALS: ABS, BV, CE, DB, DNV, LR, PRS, RS & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO₂ or 80%Ar/20%CO₂

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm ²)	470
Si	0.90	UTS (N/mm ²)	560
Mn	1.50	Elongation (%)	26
		Impact (CVN) @ -30°C (Joules)	70

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-200	18-24
0.9	70-250	18-26
1.0	80-300	18-32
1.2	120-380	18-35
1.4	150-420	22-36
1.6	225-550	28-38

PACKING: The wire can be supplied in plastic or wire basket spool packed in a cardboard box weighing 15/18 kg or Marathon Pac weighing 250/475 kg.