

# OK Autrod 12.64 GMAW ER70S-6

## Description

OK Autrod 12.64 is a copper-coated, Mn-Si alloyed G4Si1/ER70S-6 solid wire for the GMAW of non-alloyed steels, as used in general construction, automotive components, pressure vessel fabrication and shipbuilding. It has a slightly higher manganese and silicon content than OK Autrod 12.50 to increase the weld metal strength. This also promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

The wire can be used with both Ar/CO<sub>2</sub> mixed gas and pure CO<sub>2</sub> shielding gas

## Welding current

DC+

## Classifications

SFA/AWS A5.18	ER70S-6
EN 440	G4Si1

## Wire composition

C	Si	Mn
0.1	1.0	1.7

## Typical mech. properties all weld metal

Yield stress, MPa	525
Tensile strength, MPa	595
Elongation, %	26

## Charpy V

Test temps, °C	Impact values, J
+20	130
-30	70

## Approvals

ABS	3SA, 3YSA	UDT	DIN 8559
BV	SA3YM	Ü	42.039/1
CL		VdTÜV	
DB	42.039.11		
DNV	III YMS		
DS	EN 440		
GL	3YS		
LR	3 3YS		
RINA	SG56A3; SG56A2		
RS	3YMS		
Sepros	UNA 485178		
SFS	EN 440		
SS	EN 440		

## Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.6	5.0-13	50-100	16-20	0.7-1.7
0.8	3.2-10	60-185	18-24	0.8-2.5
0.9	3.0-12	70-250	18-26	0.8-3.3
1.0	2.7-15	80-300	18-32	1.0-5.5
1.2	2.3-15	120-380	18-35	1.2-8.0
1.4	2.5-12	150-420	22-36	1.7-8.5
1.6	2.3-15	120-380	18-35	1.2-8.0