

OK Autrod 12.66 GMAW

ER70S-6

Description

OK Autrod 12.66 is a copper-coated Mn-Si-alloyed solid wire designed for the mechanised downhill GMAW of pipelines in materials such as API 5L grade 52 to 70. The main application areas are pipelines, compressor stations and associated work in the oil and gas industries. This is an EN 440 G4Si1 type with an improved impurity level to meet the special requirements of this industry. It is supplied on 1 and 5 kg wire spools for use on mechanised pipe welding systems.

The wire can be used with both Ar/CO₂ mixed gas and pure CO₂ shielding gas.

Welding current

DC+

Classifications

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

Wire composition

C	Si	Mn
0.09	1.0	1.7

Typical mech. properties all weld metal

Yield stress, MPa	535
Tensile strength, MPa	600
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
+20	140
-20	100
-30	80

Approvals

VdTÜV

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	3.2-13	60-200	18-24	0.8-3.0
0.9	3.0-12	70-250	18-26	0.9-3.6
1.0	2.7-15	80-300	18-32	1.0-5.6