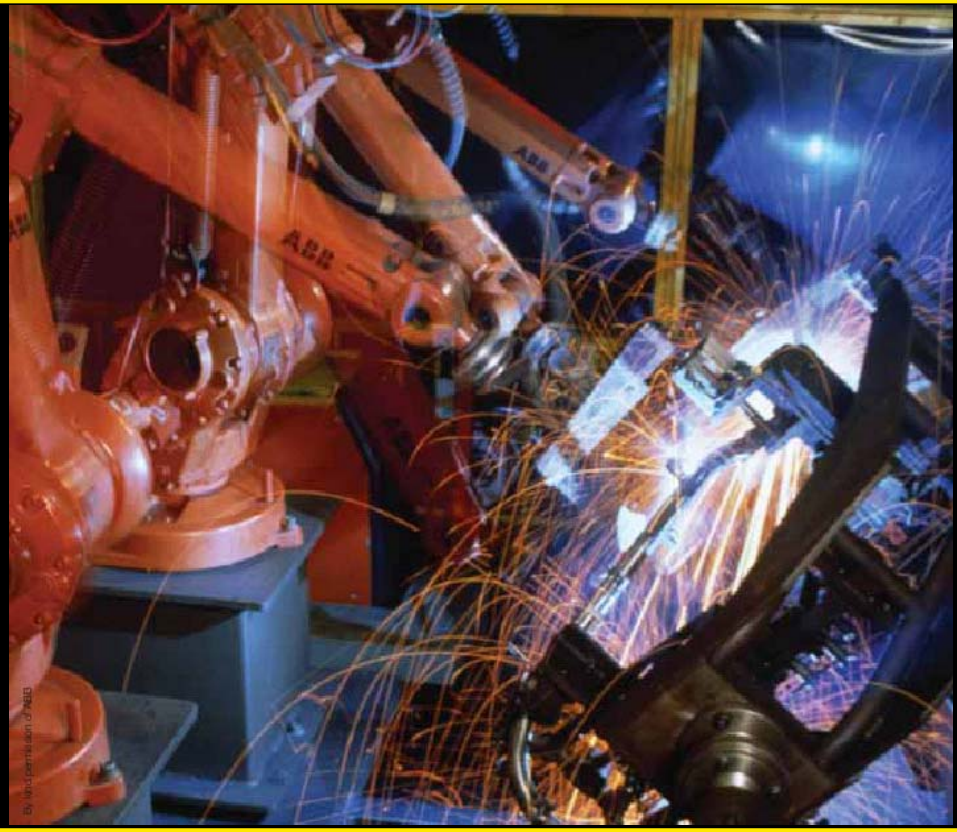
OK AristoRod™

无镀铜焊丝 – 引领未来的焊丝技术

Non Copper Coated Wire – Technology for Future



ESAB®

OK AristoRod™

- 我们想创造一种能使MAG焊达到一个新的水平的MAG焊丝

  We wanted to create a MAG wire that takes MAG welding to new performance levels.

- 所以我们发明ASC技术

  - MAG焊丝制造技术领域的一个重要的进步

  So we developed ASC

  - a major advance in MAG wire manufacturing technology.

OK AristoRod™

- 新一代的无镀层MAG焊丝
  A new generation of bare MAG wires.

- 由伊萨采用ASC（先进的表面特性）专利技术制造
  Manufactured exclusively by ESAB with ASC
  Advanced **S**urface **C**haracteristics technology.

- 焊接速度更高、焊接过程顺畅
  Faster, trouble free welding

OK AristoRod - 历史History

- 几十年来，采用镀铜实心焊丝已经成为MAG焊接的标准。然而许多用户知道，不同供货商提供的MAG焊接焊丝的质量存在很大差异。Use of copper-coated solid wires has been standard in MAG-welding for decades. Many users know, however, that considerable quality differences exist between MAG-welding wires from various suppliers.

- 铜屑会从焊丝表面脱落，堵塞导丝管，镀铜质量差时会影响导电嘴的电流传导，送丝性能是很多镀铜焊丝的弱点。Copper flakes break free, clogging liners and poor copper quality interferes with current pick up at the contact tip. The result, bad feeding and welding down time. Feeding quality is a weak point with many copper-coated wires.

- 为了避免这个问题，在八十年代和九十年代期间，许多焊材供应商推出无铜焊丝。然而由于其它的不利因素，这种焊丝从来没有被市场所接受。To avoid the problem, during the 1980s and 1990s, many welding suppliers introduced copper-free welding wires. However, they never gained acceptance in the market because of other disadvantages, such as increased sensitivity to corrosion and a high contact tip wear - especially at high wire feed speeds.

OK AristoRod 12.50 - 历史History

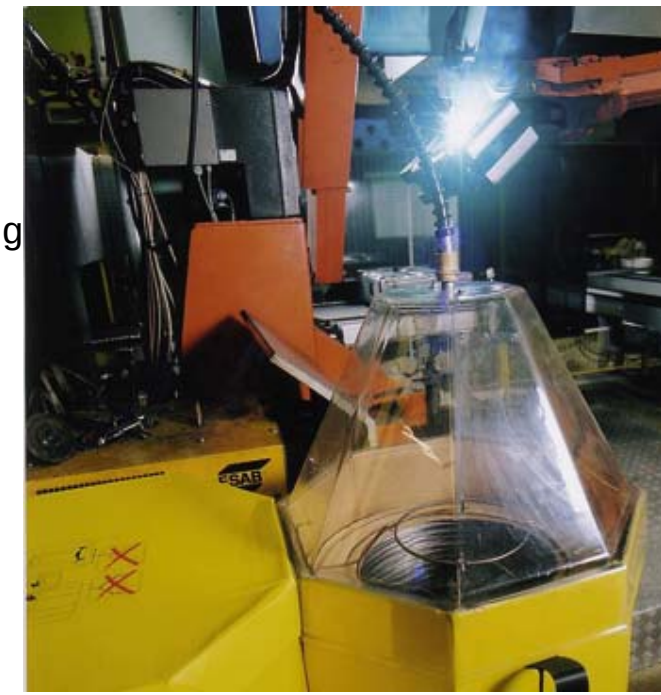
- 伊萨自1997年成功推出无镀铜MAG焊丝，最初命名为 EcoMig 然后更名为Autrod。During 1997 the ESAB Group successfully launched the first copper free MAG wire.
  - 无镀铜焊丝销量持续增长，到2002年无镀铜焊丝销量占全部MAG焊丝的17%。Copper free MAG sales in 2002 with a 17% share of the total MAG volume from a share 1997 of about 1%.
  - 在2002年之后，伊萨发明了ASC™技术 后无镀铜焊丝被命名为AristoRod 。And new name AristoRod was given after we developed ASC™ technology

- 我们创造一种能使MAG焊达到一个新的水平的焊丝
  - 迄今为止全球最好的焊丝

OK AristoRod™ - 一个真正的创新a true innovation

关键特性和好处Key Feature + Benefits

- 在很高电流时焊接时电弧非常稳定 - 可实现更高焊接速度
  Very stable arc at very high welding currents – means faster welding
- 焊接飞溅非常少 – 节约焊后打磨成本
  Extremely low level of spatter – without clean up costs
- 起弧性能卓越
  Excellent start properties – ideal for robots and mechanized welding
- 送丝送丝过程顺畅稳定Consistent, trouble-free feeding
- 减少导电嘴磨损Reduced contact tip wear
- 焊丝抗锈蚀性能更好
  Improved protection against corrosion of the wire
- 低烟尘率Low fume emission level



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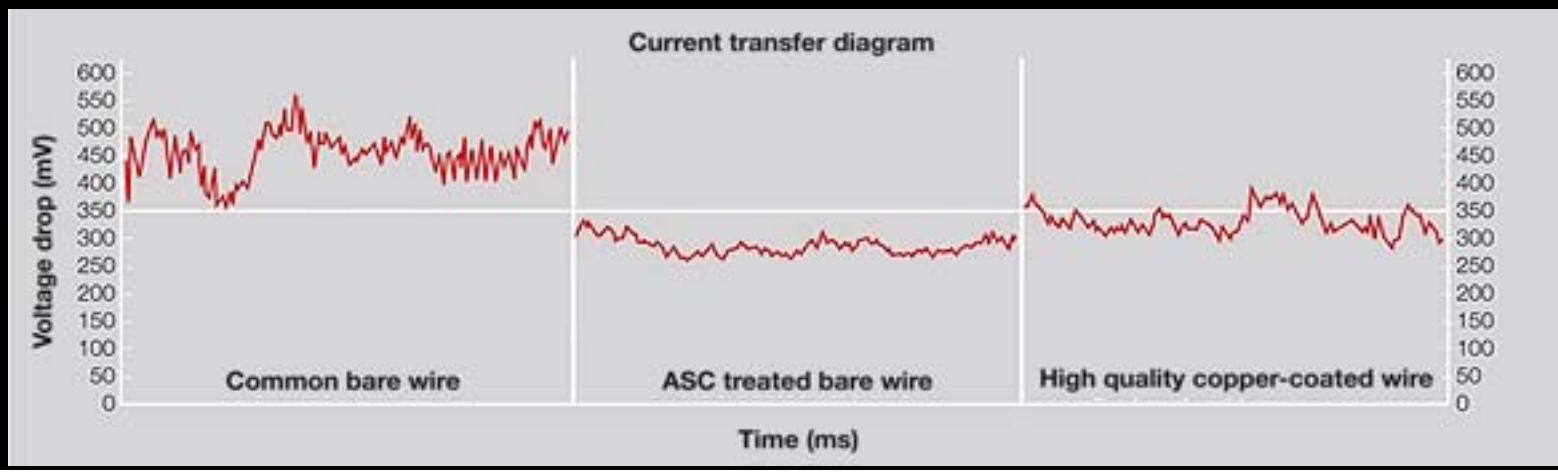
- 熔滴过渡频率至少不低于镀铜焊丝

  Current transfer at least as good as with high quality copper coated wire
- 导电嘴与焊丝之间的电压降更少Lower voltage drop between contact tip and wire
- 电弧稳定性高Improved current transfer stability



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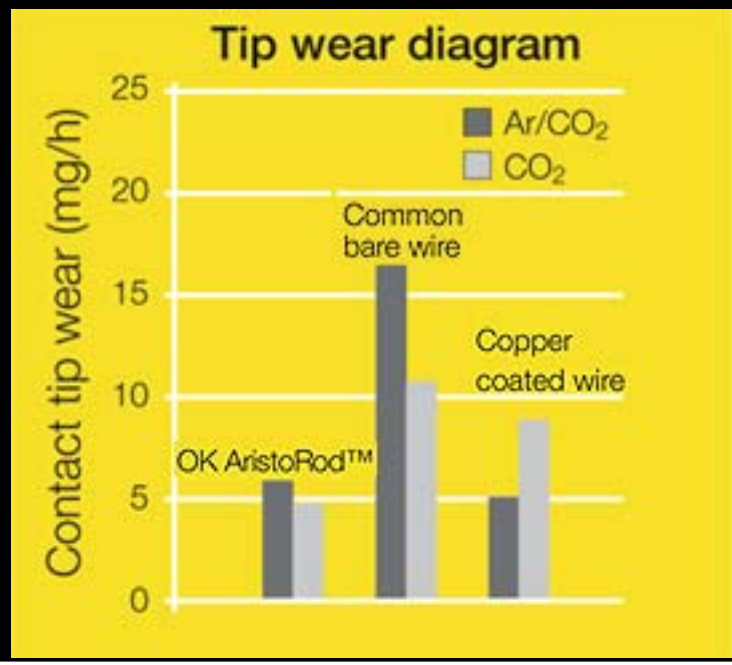
- 导电嘴磨损是不镀铜MAG焊丝常遇到的问题

  Contact tip wear is a traditional problem of bare MAG-wires.

- AristoRod焊丝的导电嘴磨损程度降低到最好的镀铜焊丝同样水平

  Contact tip wear with AristoRod reduced to the level of the best copper-coated wires.



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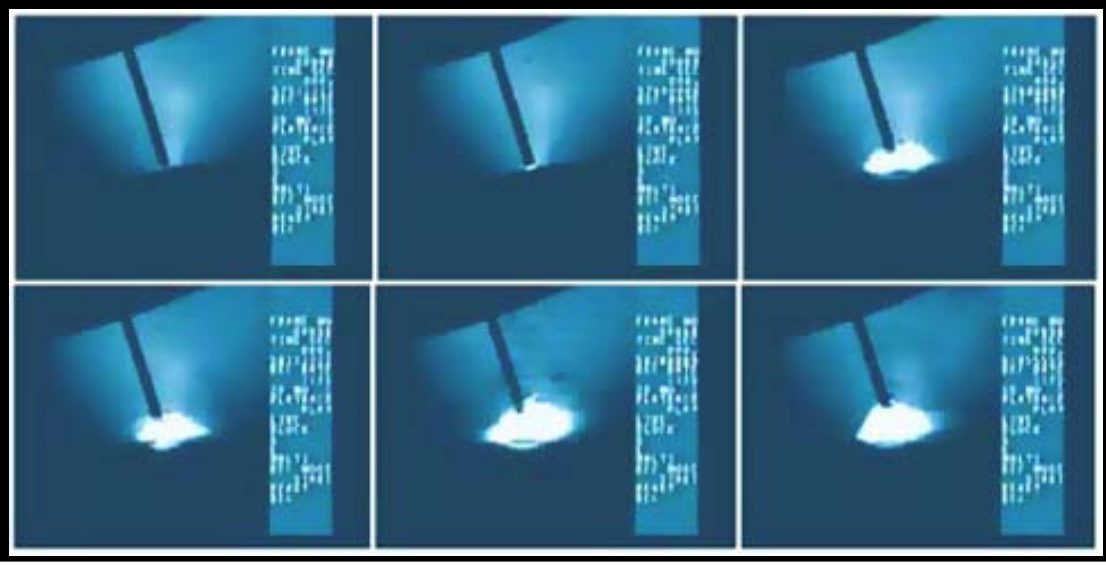
- ASC技术使得电弧更加稳定，飞溅更少

  ASC results in greater arc stability and reduced spatter.

- 高速摄影显示电弧的燃弧过程稳定且无飞溅

  High speed video recording reveals a smooth and spatter free arc ignition.



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起弧性能卓越Excellent Start Properties

测试条件**Tested with:**

OK AristoRod 12.50, 1,0mm wires
Travelling speed = 12mm/sec (72 cm/min)
Wfs = 12,0 m/min
Voltage = 31,0 volt
Burn back = 0,18 sec
Dynamic = 80%
Final pulse = 60%
Stick-out = 15mm

Repeated start and stop performed on a plate.

A close up of the picture above.

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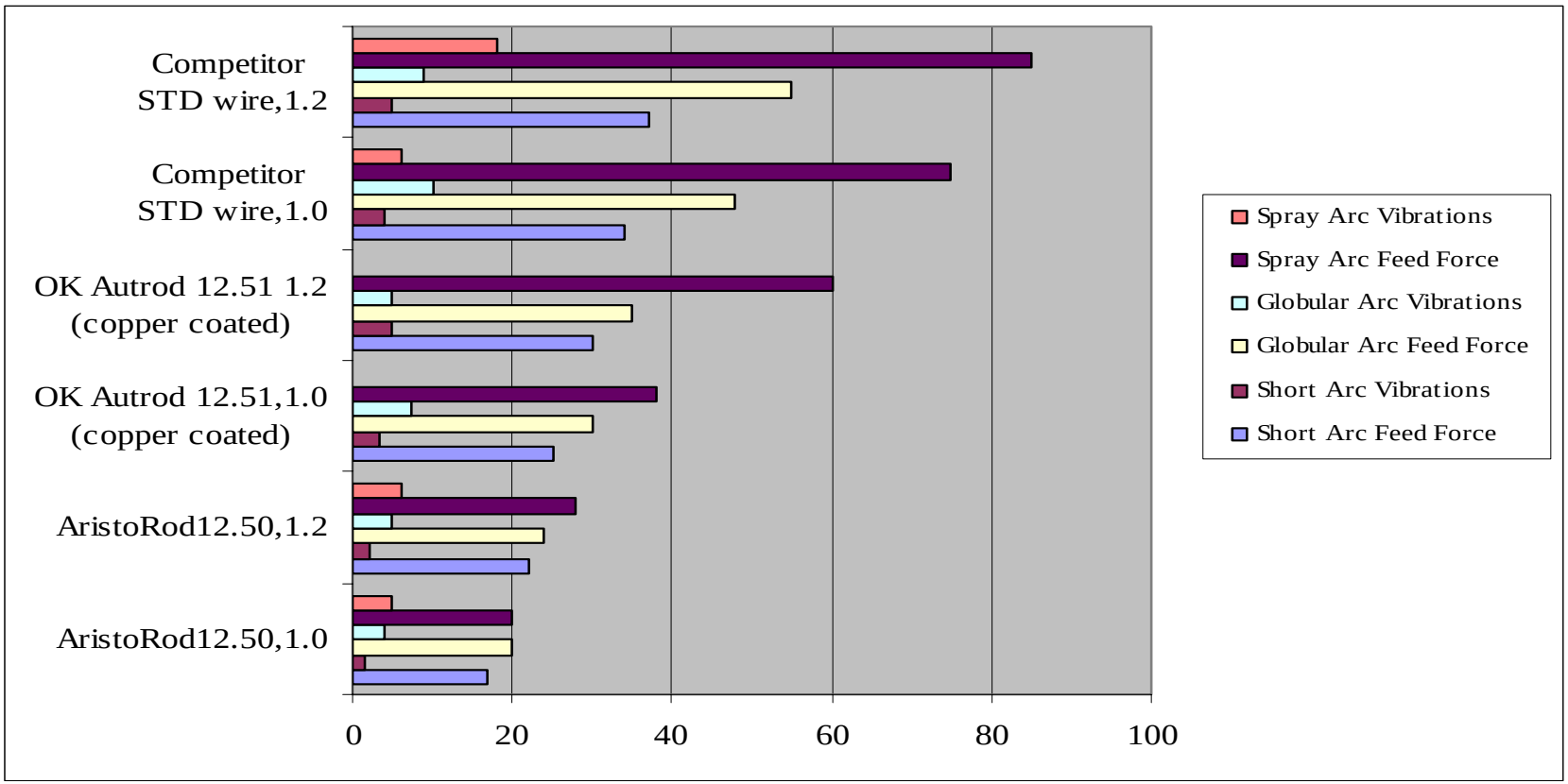
送丝稳定性Feedability



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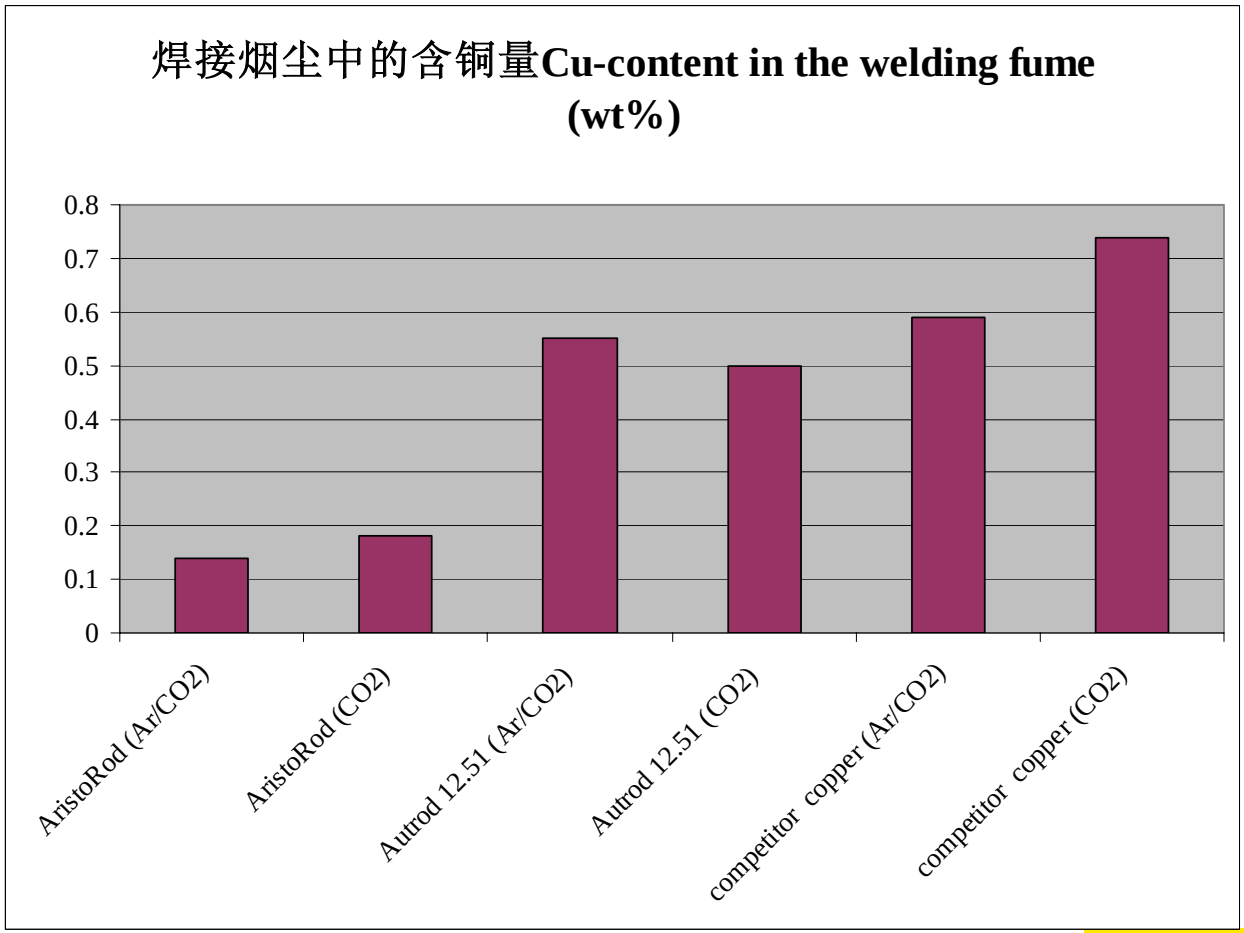
低烟尘率Low fume emission level



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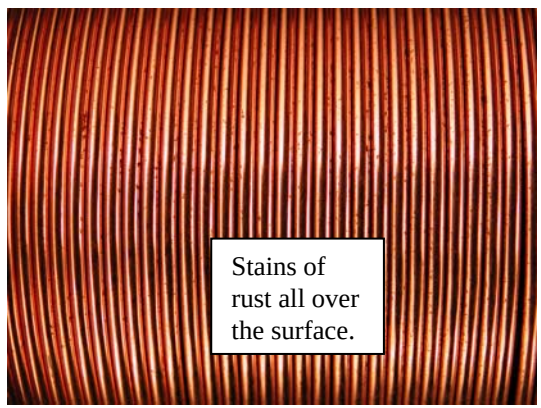
抗锈蚀性能更好Better Corrosion Resistance

耐腐蚀性试验Corrosion test

•右边照片显示了AristoRod焊丝和其它厂商铜MAG焊丝在暴露在热的环境下10天的表面状态

Photo shows AristoRod surface after 10 days of exposure to tropical conditions.

AristoRod



STD Copper Coated Wire

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产品范围The range

产品 OK AristoRodTM	AWS A5.18	焊丝类别 AWS A5.28	EN 440	EN 12534	EN 12070
12.50	ER70S-6		G3Si1		
12.57	ER70S-3		G2Si		
12.62	ER70S-2		G2Ti		
12.63	ER70S-6		G4Si1		
12.65	ER70S-6		G4Si1		
13.08		ER80S-D2	G4Mo		
13.09		ER80S-G	G2Mo		G MoSi
13.12		ER80S-G			G CrMo1Si
13.13		ER100S-G		G Mn3NiCrMo	
13.22		ER90S-G			G CrMo2Si
13.26		ER80S-G			
13.29		ER100S-G		G Mn3Ni1CrMo	
13.31		ER110S-G		G Mn4Ni2CrMo	

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供选择包装方式**Packaging options**

- 马拉松桶 Marathon Pac.
  - 250 kg装AristoRod焊丝
    250 kg of AristoRod welding wire
  - 巨型马拉松桶Jumbo Marathon Pac
    475 kg装AristoRod焊丝
    475 kg of AristoRod welding wire

- 18kg 盘丝spools

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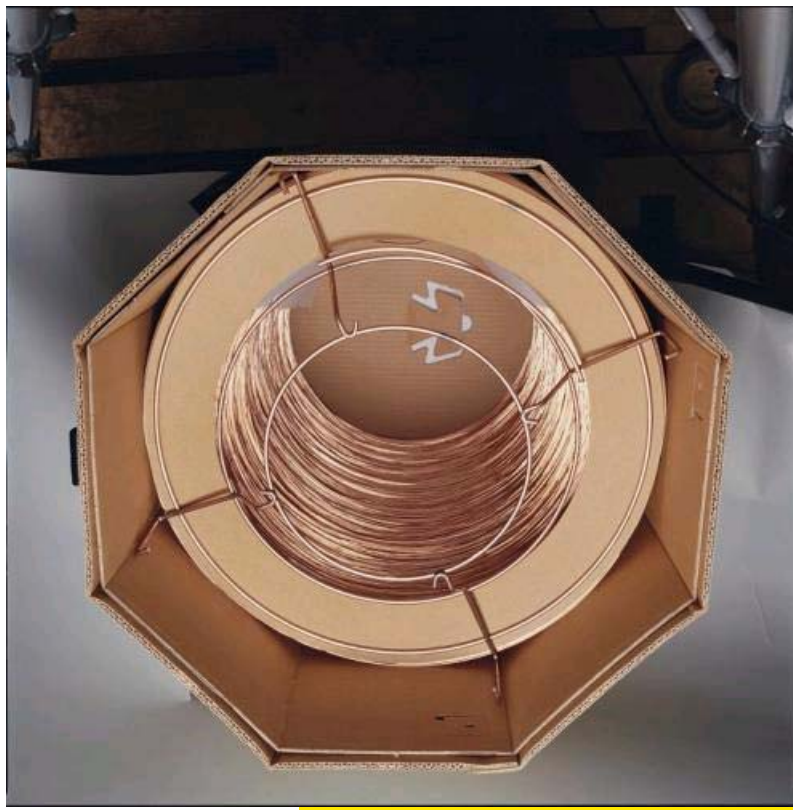
供选择包装方式**Packaging options**



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供选择包装方式**Packaging options**

- 无穷尽的马拉松桶Endless Marathon Pac.
- 250或475 kg的AristoRod焊丝
  250 or 475 kg of AristoRod welding wire.
- 鼓形圆筒的连接方式形成连续的焊丝供给
  Drums connected to form continuous supply of welding wire.
- 伊萨专门的焊丝对接焊设备Special wire butt welder available from ESAB.

马拉松桶(Marathon Pac™)- 搬运Handling

用完桶易于处理**Easy Drum Disposal**

废弃处理**Disposal**

- 节省废弃处理成本**Cost saving on waste disposal**
- *马拉松*装空桶完全可以回收**Empty Pac fully recyclable**

1. 解除带子
Remove straps

2. 将底板向内推进
Push bottom panel inwards

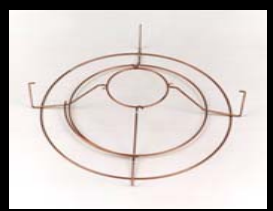
3. 取出底板
Remove bottom panel

4. 将桶身踩平
Flatten the Pac

巨型马拉松桶(Marathon Pac™) -搬运Handling

安装

放丝锥



推车

吊轭

接到塑料罩的快速连接导管.