

GRICON BLACK



IDENTIFICATION : GRICON BLACK, E 6013

CLASSIFICATION : AWS/SFA 5.1: E 6013, IS: 814 2004: ER-4211, BS: E 4322 R11 DIN :E 4322R 312

DESCRIPTION :

A medium-coated rutile electrode suitable for shipbuilding and structural steels as well as general purpose fabrication in mild steels.

CHARACTERISTICS : Stable arc with easy striking and restriking properties, low spatter and minimum quantity of easily detachable slag makes this electrode stable in all positions. Ease of welding and shiny bead appearance are present even in vertical down position.

TYPICAL USES :

- Storage tank, railway wagons, construction equipments, ship building,
- Steel furniture, sheet metal work, automobile bodies, general fabrication etc.

ASME IX Qualification : QW -432 F.No 2 QW- 442 A.No 1

WELD METAL ANALYSIS (RANGE) %:

C	Mn	Si	S	P
0.12 max	0.35- 0.50	0.15-0.30	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES (RANGE) :

Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V-notch Impact Value
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460-550	360-470	22-28	Temp	Joules
			0°C	47-90

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC(+/-)	PACKING/BOX (PCS)	WEIGHT/1000 Pcs (Kg)
2.50	350	55-85	225X4=900	17.80
3.20	350	90-125	140X4=560	26.70
3.20	450	90-125	140X4=560	34.3
4.00	450	120-180	90X4=360	55.5
5.00	450	170-220	60X4=240	85.00
6.30	450	210-250	35X4=140	135.00