

GRICON RED



IDENTIFICATION : GRICON RED, E6013

CLASSIFICATION : AWS/SFA 5.1: E6013, IS : 814 2004 : ER4111,

CHARACTERISTICS :

Medium coated rutile type, all-position versatile electrode for wide variety of mild steel fabrication welding. It has excellent operatability and high welders appeal. Ideal for fillet and butt joint an all positions.

TYPICAL APPLICATIONS :

General purpose mild steel fabrication such as plate work, pipes and flanges, tubular section frames, etc. steel furniture and window grill, textile machinery, railway wagons, coaches and trailers etc.

Redrying Temp. :100-120°C for 1 Hr.

WELD METAL ANALYSIS (RANGE) %:

C	Mn	Si	S	P
0.10 max	0.32-0.55	0.15-0.35	0.03 Max	0.03 Max

MECHANICAL PROPERTIES (RANGE) :

Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%) (L=4D)	Charpy V-notch impact strength
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450-550	360-460	22-28	Temp	Joules
			27+2°C	50-90

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (+/-)	Packing Per Box (Pcs)	Weight 1000 Pcs (KGS)
2.50	350	65-100	240X4=960	18.00
3.15 / 3.20	350	80-135	150X4=600	26.7
4.00	450	120-175	90X4=360	55.8
5.00	450	150-210	60X4=240	85.8