

GEECON GREY

IDENTIFICATION

Geecon Grey, E 6012

CLASSIFICATION

AWS/SFA 5.1: E 6012, IS: 814 -1991: ER-4111, BS: E 4311 R12

DIN: E 431 R(C) 312

DESCRIPTION

An extruded rutile-based, light coated general purpose electrode for all position welding. Arc is stable. Striking and re-striking properties are excellent. Slag is easily removable. Weld bead is uniformly rippled. Penetration is medium. Low spatter loss. Good ability to bridge the gaps of poorly fit up joints.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.10 max	0.35 - 0.45	0.15 - 0.35	0.030 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
470 - 530	380 - 440	22 - 28	27°C	50 - 100

TYPICAL APPLICATIONS

Weldable on structural steels, naval steel, steel furniture fabrications, window grills, agricultural implement parts, steel tubes, storage tanks, ship building, barges, railway wagons, coaches, tractor trailers, etc.

WELDING POSITION :



1G 2F 2G 3G 4G

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+/-)	Packing / Box (Pcs)
2.5	350	55 - 85	300 x 4 = 1200
3.15 / 3.20	450	80 - 120	150 x 4 = 600
4	450	140 - 170	100 x 4 = 400
5	450	180 - 220	65 x 4 = 260