

GEECON PINK

IDENTIFICATION

Geecon Pink, E 6013

CLASSIFICATION

AWS/SFA 5.1: E 6013, IS: 814 - 2004: ER-4211X

BS: E4322R21, DIN: E 4322R322

DESCRIPTION

An extruded rutile-based, medium heavy coated electrode.

It is weld able in all positions with minimum spatter. It has excellent striking and restricting properties. The weld bead is uniformly rippled and shining. The slag is compact, uniform and easy to remove and deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.10 max	0.35 - 0.60	0.15 - 0.50	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
460 - 560	370 - 480	22 - 30	Temp	Joules
			0°C	47 - 90

TYPICAL APPLICATIONS

Suitable for radiographic quality welding on critically stressed joints. Applicable for repair welding/surfacing of naval steels, boiler steels and structural steels. Widely used in welding of steel structures, heavy-duty boilers and pressure vessels, heat exchanges, ships and barges, pipelines, storage tanks, bridges, railway coaches etc.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+/-)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 85	5 x 4 = 20	225 x 4=900
3.15 / 3.20	350	95 - 130	5 x 4 = 20	120 x 4 = 480
3.15 / 3.20	450	95 - 130	5 x 4 = 20	120 x 4 = 480
4	450	130 - 180	5 x 4 = 20	80 x 4 = 320
5	450	200 - 240	5 x 4 = 20	50 x 4 = 200