

GEECON PURPLE

IDENTIFICATION

GEECON PURPLE, E 7016

CLASSIFICATION

AWS/SFA 5.1: E7016 IS: EB5224H3X BS: E 5144B24 (H),
DIN: 5144B1026

DESCRIPTION

An extruded, heavy coated, hydrogen - controlled electrode. Weldable in all positions except vertical down. Welding technique including arc striking/restricting calls for practical experience for best result. The bead appearance is fine with uniform ripples and the slag is compact, thick and easily detachable.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Mn + Ni + Cr + Mo + V
0.1 max	0.80 - 1.60	0.75 max	0.03 Max	0.03 max	0.3 max	0.2 max	0.3 max	0.08 max	1.75 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
510 - 610	440 - 540	24 - 30	27°C	120 - 210
			0°C	100 - 180
			-20°C	90 - 160
			-29°C	50 - 125

TYPICAL APPLICATIONS

- For radiographic quality welding of highly stressed joints in steel structures, heavy-duty boilers and pressure vessels, railway wagons, coaches and trailers etc.
- Also for maintenance welding / surfacing of cast steel / fine grained / heat treated steel and wrought steel.
- Excellent for welding of higher carbon and higher sulphur steel which are susceptible to hydrogen induced cracking.
- Recommended for welding steels of unknown composition

WELDING POSITION :



PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	2 X 6 = 12	225 x 4 = 900
3.15 / 3.20	450	80 - 130	2 X 6 = 12	120 x 4 = 480
4	450	110 - 180	2 X 6 = 12	70 x 4 = 280
5	450	150 - 220	2 X 6 = 12	55 x 4 = 220