

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.

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 is present even in vertical down position.

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

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
460 - 550	360 - 470	22 - 28	0°C	47 - 90

TYPICAL APPLICATIONS

- 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

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+/-)	Packing / Box (Pcs)
2.5	350	55 - 85	225 X 4 = 900
3.15 / 3.20	350	90 - 125	140 X 4 = 560
3.15 / 3.20	450	90 - 125	140 x 4 = 560
4	450	120 - 180	90 X 4 = 360
5	450	170 - 220	60 X 4 = 240