

GRICON BLUE

IDENTIFICATION

Gricon Blue, E 6013

CLASSIFICATION

AWS/SFA 5.1: E 6013, IS 814: 2004: ER-4222X,
BS: E 4322 R22, DIN: E 4333 R 322

DESCRIPTION

An extruded rutile-based, heavy coated, all-position electrode. It has a stable and quiet arc, extraordinary fine and uniformly rippled bead and self-peeling slag. The weld deposit is radiographically sound.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.10 max	0.30 - 0.65	0.15 - 0.35	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

UTS (N/mm ²)	PS (N/mm ²)	EL (%) (L=5D) (L=4D)	CVN Impact Value	
			Temp	Joules
460 - 550	360 - 480	24 - 30	0°C	47 - 95

TYPICAL APPLICATIONS

- Ideally suitable for vertical up and overhead welding of radiographic soundness in high-pressure boilers and pipelines.
- Frequently used for final 'fill' run of groove-joints due to shiny appearance and least spatter.
- Also applicable for repair welding and surfacing Naval steels, Boiler Steels and Structural steels

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+/-)	Packing / Box (Pcs)
2.5	350	60 - 85	150 X 4 = 600
3.15 / 320	350	95 - 130	105 X 4 = 420
3.15 / 320	450	95 - 130	105 X 4 = 420
4	450	130 - 180	60 X 4 = 240
5	450	150 - 240	40 X 4 = 160