

GRICON BROWN

IDENTIFICATION

Gricon Brown, 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, medium 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	0.35 - 0.60	0.18 - 0.35	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (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.
- Also applicable for repair welding and surfacing Naval steels, Boiler Steels and Structural steels. IS : 2062 Grade A, B, wagons, automobile industry, etc.

WELDING POSITION:



1G 2F 2G 3G 4G 5G

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	450	90 - 125	140 X 4 = 560
4	350	120 - 180	90 X 4 = 360
4	450	120 - 180	90 X 4 = 360
5	450	170 - 220	60 X 4 = 240