

# GRICON INDIGO

## IDENTIFICATION

Gricon Indigo, E 6020

## CLASSIFICATION

AWS A 5.1 E 6020 IS : EA 4255 X

## DESCRIPTION

A heavy coated electrode producing fluid slag, for flat, horizontal and vertical welding. The electrode is specially designed quality welds are required.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.07 max	0.7	0.23	0.03 max	0.03 max

## MECHANICAL PROPERTIES (RANGE)

UTS (Kg/mm <sup>2</sup> )	YS (Kg/mm <sup>2</sup> )	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
430 - 540	380 min	24	0°C	50

## TYPICAL APPLICATIONS

INDIGO is an iron oxide type electrode for welding of carbon steels. The welds are of all radiographic quality. Typical applications include locomotive fire boxes, rotary kilns, heavy structures, engine frames, bases, etc.

**REDRYING TEMPERATURE** : 120°C for 30 min.

**WELDING POSITION** : Fillet - Flat/Horizontal

## PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+/-)	Packing / Box (Pcs)
2.5	350	60 - 90	150 x 4 = 600
3.15 / 3.20	350	100 - 140	100 x 4 = 400
4	450	150 - 210	60 x 4 = 240
5	450	180 - 260	40 x 4 = 160