

GRICON LOWSIL

IDENTIFICATION

Gricon Lowsil, E 6013

CLASSIFICATION

Not Applicable Nearest AWS/SFA 5.1 E6013

DESCRIPTION

Electrode to give very low silicon deposit for galvanizing baths. Specially formulated mild steel electrode deposits weld metal with very low silicon content. It is designed specifically for the fabrication and repair of hot-dip zinc galvanizing baths and lead pots. A low silicon content in the weld metal is necessary to resist corrosion / erosion by molten, zinc at the operating temperature of 450-500°C. The electrode is also recommended for welding articles made from low silicon galvanizing steels intended for subsequent bright zinc coating.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.09 max	0.20 - 0.6	0.05 max	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)
430 - 500	360 - 430	24 - 32

TYPICAL APPLICATIONS

Low silicon steels e.g. BS 2848, ARMCO iron or equivalent used for fabrication and repair of hot-dip galvanizing baths.

MICROSTRUCTURE: Ferrite.

WELDING POSITION :



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	90 - 130	100 X 4 = 400
3.15 / 3.20	450	90 - 130	100 X 4 = 400
4	450	140 - 180	60 X 4 = 240
5	450	180 - 220	40 X 4 = 160