

GRICON ORANGE

IDENTIFICATION

GRICON ORANGE, E 7014

CLASSIFICATION

AWS/SFA 5.1: E7014, IS : 814 1991: ERR-5222-XJ,
BS : E4332 R R13056 DIN :E5122AR11120

DESCRIPTION

An extruded heavy coated, iron powder, rutile based all position electrode. The Electrode is usable in all position including vertical down. It gives a very smooth arc and low spatter characterized by ease of operation in all positions. Easy striking and restriking.

Welding speed is high with deep penetration due to addition of Iron Powder. The deposition efficiency is approximately 130%. Slag is compact and easily detachable. The deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.10 max	1.25 max	0.90 max	0.030 max	0.030 max	0.30 max	0.20 max	0.30 max	0.08 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
510 - 600	430 - 500	22 - 28	Temp	Joules
			0°C	47 - 88

TYPICAL APPLICATIONS

- For welding heavy structural steel as in storage tanks, ship building, boilers, pressure vessels, building structures, machinery parts, truck frames and bodies.
- Used for repairing steel castings.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+ / -)	Packing / Box (Pcs)
2.5	350	70 - 105	150 x 4 = 600
3.15 / 3.20	450	100 - 140	100 x 4 = 400
4	450	140 - 190	60 x 4 = 240
5	450	180 - 240	40 x 4 = 160
6.3	450	220 - 300	25 x 4 = 100