

GRICON RED

IDENTIFICATION

Gricon Red, E 6013

CLASSIFICATION

AWS/SFA 5.1: E6013, IS : 814 2004 : ER4111

DESCRIPTION

Medium coated rutile type, all-position versatile electrode for wide variety of mild steel fabrication welding. It has excellent operatability and high welders appeal. Ideal for fillet and butt joint an all positions.

WELD METAL ANALYSIS (RANGE) %

| C | Mn | Si | S | P |
|----------|-------------|-------------|----------|----------|
| 0.10 max | 0.32 - 0.55 | 0.15 - 0.35 | 0.03 max | 0.03 max |

MECHANICAL PROPERTIES (RANGE)

| TS (MPa) | YS (MPa) | EL (%) (L=4D) | CVN Impact Value | |
|-----------|-----------|------------------|------------------|---------|
| | | | Temp | Joules |
| 450 - 550 | 360 - 460 | 22 - 28 | 27+2°C | 50 - 90 |

TYPICAL APPLICATIONS

General purpose mild steel fabrication such as plate work, pipes and flanges, tubular section frames, etc. steel furniture and window grill, textile machinery, railway wagons, coaches and trailers etc.

REDRYING TEMPERATURE : 100 - 120°C for 1 Hr.

WELDING POSITION :



PACKING PARAMETERS

| Size (mm) | Length (mm) | Amps AC / DC (+/-) | Packing / Box (Pcs) |
|-------------|-------------|-----------------------|------------------------|
| 2.5 | 350 | 65 - 100 | 150 x 6 = 900 |
| 3.15 / 3.20 | 350 | 80 - 135 | 90 x 6 = 540 |
| 3.15 / 3.20 | 450 | 80 - 135 | 90 x 6 = 540 |
| 4 | 450 | 120 - 175 | 60 x 6 = 360 |
| 5 | 450 | 150 - 210 | 40 x 6 = 240 |