

GRICON ROSE

IDENTIFICATION

Gricon Rose, E 6027

CLASSIFICATION

AWS/SFA 5.1 : E 6027 , IS : 814 1991 : ES-4442

BS : E4300A44, DIN : ETfEs VIII

DESCRIPTION

An extruded rutile-based ,super heavy coated iron powder electrode. It is usable for deep penetration Flat Cut Fillet Welds (H-Fillets, F). It has a highly concentrated arc with low spatter. Slag is heavy, brittle and easily detachable. Deposition efficiency is above 100 %.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.06 - 0.10	0.40 - 0.85	0.6 - 0.95	0.030 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
430 - 550	390	22 - 28	Temp	Joules
			27°C	49

TYPICAL APPLICATIONS

Suitable for radiographic quality joints on heavy plates (upto 14 mm) without the necessity for edge preparation by bevelling. Usable for heavy deck plates, structurals, etc, including depositing sealing run on the backside without necessity of chipping out the root bead. Also used for fillet weld with penetration beyond the root as in plate girders for bridgework.

NO WELDING POSITION

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (-)	Packing / Box (Pcs)
3.15 / 3.20	450	80 - 150	100 x 4 = 400
4	450	180 - 250	60 x 4 = 240
5	450	270 - 350	40 x 4 = 160