

GRICON VIOLET

IDENTIFICATION

Gricon Violet, E 6011

CLASSIFICATION

AWS/SFA 5.1 : E6011

DESCRIPTION

Cellulosic coated all position electrode designed for use with AC power sources. The electrode provides stable arc characteristics and good penetration. The deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

| C | Mn | Si | S | P |
|----------|-------------|-------------|-----------|-----------|
| 0.24 max | 0.30 - 0.60 | 0.12 - 0.30 | 0.030 max | 0.030 max |

MECHANICAL PROPERTIES (RANGE)

| TS (MPa) | YS (MPa) | EL (%) (L=4D) | CVN Impact Value | |
|-----------|-----------|---------------|------------------|----------|
| | | | Temp | Joules |
| 450 - 580 | 360 - 480 | 22 - 28 | -30°C | 50 - 100 |

TYPICAL APPLICATIONS

Galvanized steel work, General fabrication, Railroad cars, shipbuilding, Structural work, etc.

WELDING POSITION :



PACKING PARAMETERS

| Size (mm) | Length (mm) | Amps AC / DC (+) | Packing / Box (kg) |
|-------------|-------------|------------------|--------------------|
| 2.5 | 350 | 60 - 100 | 2 x 5 = 10 |
| 3.15 / 3.20 | 350 | 80 - 125 | 2 x 5 = 10 |
| 4 | 350 | 130 - 160 | 2 x 5 = 10 |
| 5 | 350 | 160 - 200 | 2 x 5 = 10 |