

# 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