

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