

GRICON WHITE

IDENTIFICATION

GRICON WHITE E6010

CLASSIFICATION

AWS/SFA 5.1 E6010;

IS 814: EC4310X, EN 499: E 3522C25;

DIN 1913: E4343C4; ISO 2560: E433C4

DESCRIPTION

A medium coated, all position, cellulosic electrode with a forceful penetrating arc for pipe welding suitable for cross-country pipe lines for root, filler and capping passes using down-hand welding technique. Because of the forceful arc, the electrode is recommended for depositing root run in 5G and 6G position during construction of in plant pipelines. Weld metal is highly ductile and of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.14 max	0.30 - 0.60	0.10 - 0.40	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact	
460 min	390 min	22 min	Temp	Joules
			-30°C	47 min

TYPICAL APPLICATIONS

- Pipe Lines, for depositing root run in the in-plant pipe lines in 5G & 6G position.
- For Cross-country pipeline, root, filler & capping passes.
- Pipe Steels API 5LX-grade 42-56
- Specially suited for pressure pipelines which cannot be welded from inside.

WELDING POSITION :

5G, 1G, 4G

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)
2.5	350	50 - 80	2 x 5 = 10
3.15 / 3.20	350	80 - 130	2 x 5 = 10
4	350	110 - 160	2 x 5 = 10
5	350	160 - 250	2 x 5 = 10