

GRICON YELLOW

IDENTIFICATION

GRICON YELLOW, E 7014

CLASSIFICATION

AWS/SFA 5.1 : E 7014, IS : 814 1991 : ERR-5222-XJ

BS : E4332 R R13056, DIN : E5122AR11120

DESCRIPTION

An extruded rutile-based, heavy coated iron powder electrode. The electrode is suitable for flat and horizontal positions and is used for high speed welding with deposition efficiency of approximately 200%. Extremely stable arc with negligible spatter. Extremely smooth weld finish and easy slag detach. Sound radiography.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.10 max	0.40 - 0.65	0.40 max	0.030 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
510 - 550	430 min	24 - 28	Temp	Joules
			0°C	49

TYPICAL APPLICATIONS

- The electrode is used for heavy structural steel work like cranes and bridge girders, ship building, bridges, heavy storage tanks, railway coaches and wagons, heavy machinery bases, pressure vessels and boilers, earth moving equipment.
- Specially applicable for building up and finishing run in horizontal fillet welding.

REDRYING TEMPERATURE : 100°C for 30 minutes

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (-)	Packing / Box (kg)
2.5	350	60 - 85	75 x 4 = 300
3.15 / 3.20	450	100 - 150	50 x 4 = 200
4	450	160 - 200	30 x 4 = 120
5	450	200 - 250	20 x 4 = 80