

GEECON PINK

IDENTIFICATION: GEECON PINK, E 6013

CLASSIFICATION: AWS/SFA 5.1: E 6013, IS: 814 - 2004: ER-4211X
BS: E4322R21, DIN: E 4322R322

APPROVALS: IRS, ABS, LRS, DNV, BVII, BIS, IBR, KVAERNER, TOYO, MMD, BHEL, BHVP, THERMAX, MN DASTUR, AND HPCL

DESCRIPTION:

An extruded rutile-based, medium heavy coated electrode.

CHARACTERISTICS:

It is weld able in all positions with minimum spatter. It has excellent striking and restricting properties. The weld bead is uniformly rippled and shining. The slag is compact, uniform and easy to remove and deposited weld metal is of radiographic quality.

TYPICAL USES:

Suitable for radiographic quality welding on critically stressed joints. Applicable for repair welding/surfacing of naval steels, boiler steels and structural steels. Widely used in welding of steel structures, heavy-duty boilers and pressure vessels, heat exchanges, ships and barges, pipelines, storage tanks, bridges, railway coaches etc.

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (+/-)	PACKING/BOX (PCS)	WEIGHT/1000 Pcs (Kg)
2.50	350	60-85	225X4=900	18.89
3.15/3.20	350	95-130	120X4=480	29.58
3.15/3.20	450	95-130	120x4=480	39.17
4.00	450	130-180	80x4=320	59.38
5.00	450	200-240	50x4=200	94.00
6.30	450	250-320	30x4=120	145.0

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.10 max	0.35-0.60	0.15-0.50	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V-notch Impact Value	
			Temp 0°C	Joules
460-560	370-480	22-30		47-90

Manufactured by: GEE LIMITED

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West)
Thane, Maharashtra, India.
Website: www.geelimited.com

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