

GP 6012

PRODUCT DATA SHEET



GENERAL PURPOSE VERSATILE ELECTRODE

45
OCV

DC
AC

MILD STEEL & IRON POWDER ELECTRODES

GP 6012

- General Purpose Versatile Electrode.
- High Operator Appeal!
- All Positional Welding Capabilities.
- Ideal for the Vertical-Down Welding of Thin Steel Sections.
- Quite, Smooth Arc Action.
- Excellent for welding joints with poor fit-up.

CLASSIFICATIONS:

ISO AS/NZS 4855:	B E4313 A
AWS/ASME-SFA A5.1:	E6013

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	430 MPa
Tensile Strength	490 MPa
Elongation	29%
CVN Impact Values	80 J av @ 0°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.07%
Mn:	0.45%
Si:	0.30%

DESCRIPTION AND APPLICATIONS:

GP 6012 is a versatile, user friendly, G.P. electrode, suitable for welding in all positions. GP 6012 has a unique flux coating that offers exceptional welder appeal and makes for easy welding of the most difficult jobs.

Features include:

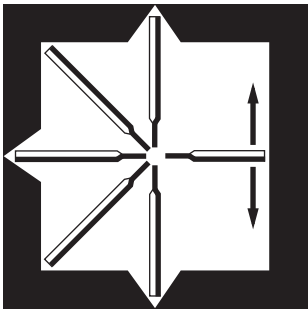
- Quick freezing, self releasing slag for exceptional control when welding in the vertical-down and other difficult positions.
- Excellent slag detachability under high heat build-up conditions.
- Superb for welding joints with poor fit-up (gaps and misalignment etc).
- Easy arc starting and stability on low voltage (greater than 45 O.C.V.) AC current welding machines.
- Medium penetrating arc, useful for welding thin and light gauge steels.
- Impressive touch welding capabilities.

Due to GP 6012's host of versatile features it is suitable for a wide range of welding applications in the light to medium structural steel industry including,

- Wrought iron furniture,
- Mild steel plate, sheet metal and galvanised iron sheet,
- Rolling stock and railway maintenance work,
- Square or rectangular hollow tube sections (RHS etc),
- Pipes and low pressure pipelines,
- Ducting, hoppers and tanks,
- Plus a wide range of G.P. welding applications such as, gates, security grills, barbecues, trolleys, letter boxes, trestles, billy carts, shelved storage units etc.

WELDING POSITIONS:

All positional - welding.



PACKAGING & OPERATING DATA:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	CARTON	PART NO.
2.5	300	55	55-80	5kg	15kg - 3 x 5kg	611142
3.2	350	30	90-130	5kg	15kg - 3 x 5kg	611143
4.0	350	19	130-180	5kg	15kg - 3 x 5kg	611144

