

Key Facts

- Medium coated Cellulose, electrode for welding in all positions including vertical-down on both AC/DC current
- Flexibility
- Less experienced welder will find this product easier to use.

Description

A rutile type electrode with easy starting characteristics. Recommended for the less experienced welder as it is so easy to use due to a self releasing slag and regularity of the deposit. Welding positions include flat horizontal, vertical up and overhead.

Classification

AWS A5.1: E6012

Welding Positions

Flat, horizontal, vertical-up, and overhead.

Markings & Identification

End tip Colour: Brown
 End side Colour: White
 Printing: GEMINI 12

Applications

These electrodes can be used for all general welding of structural steel, wrought iron, gates, galvanised steel and thinner sections.



Typical All Weld Metal Analysis

| C - Carbon | Mn - Manganese | Ni - Nickel |
|------------|----------------|-------------|
| 0.070% | 0.300% | 0.100% |

Typical All Weld Metal Mechanical Properties

| | |
|---------------------------|--|
| Yield Strength: | 410N/mm ² |
| Tensile Strength: | 560 MPa |
| Elongation (5xD): | 25% |
| Reduction of Area: | 60% |
| Impact Strengths ISO-V | 100J @ +20°C 60J @ 0°C 50J @ -20°C |

Packaging & Ordering Information

| Size | Packet | Ctn | Current Range | Part Number |
|-------|--------|------|---------------|-------------|
| 1.6mm | 2kg | 30kg | 40-55 | 100016 |
| 2.0mm | 2kg | 30kg | 45-60 | 100011 |
| 2.6mm | 2kg | 30kg | 70-95 | 100012 |
| 3.2mm | 5kg | 30kg | 100-130 | 100013 |
| 4.0mm | 5kg | 30kg | 150-180 | 100014 |