

GP 6012

45
OCVDC
AC

- ▲ 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:

AS/NZS 1553.1: E4112-0.
AWS/ASME-SFA A5.1: E6013.

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, billiard carts, shelved storage units etc.

Packaging and Operating Data:

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

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	55	55-80	5kg	15kg - 3 x 5kg	611142
3.2	380	30	90-130	5kg	15kg - 3 x 5kg	611143
4.0	380	19	130-180	5kg	15kg - 3 x 5kg	611144

APPROVALS:

Lloyds Register of Shipping	Grade 2.
American Bureau of Shipping	Grade 2.
Det Norske Veritas	Grade 2.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

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

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 0.45%	Si: 0.30%
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All positional - welding