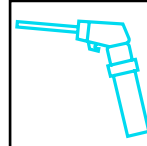


# WELDING CONSUMABLES

## MILD STEEL AND IRON POWDER ELECTRODES



## SECTION THREE

## GP 6012

45  
OCV
**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%

**APPROVALS:**

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

- ▲ Versatile General Purpose Electrode.
- ▲ All Positional Welding Capabilities.
- ▲ Ideal for the Vertical-Down Welding of Thin Steel Sections.
- ▲ Wrought iron furniture.
- ▲ Suitable for welding Mild steel plate, sheet metal and galvanised iron sheet, ducting, hoppers, tanks, pipes and low pressure pipelines.
- ▲ Pipes and low pressure pipelines.
- ▲ Excellent for welding joints with poor fit-up.

**Classifications:**

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

**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
2.5	300	55	55 – 80	2.5kg	15kg – 6 x 2.5kg	612142
3.2	380	30	90 – 130	5kg	15kg – 3 x 5kg	611143
3.2	380	30	90 – 130	2.5kg	15kg – 6 x 2.5kg	612143
4.0	380	19	130 – 180	5kg	15kg – 3 x 5kg	611144

## FERROCRAFT 12XP

45  
OCV
**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

Yield Stress	460 MPa
Tensile Strength	500 MPa
Elongation	27%
CVN Impact Values	75J av @ 0°C.

**TYPICAL ALL WELD METAL ANALYSIS:**

C: 0.07% Mn: 0.60% Si: 0.50%

**APPROVALS:**

Lloyds Register of Shipping	Grade 2, 2Y.
American Bureau of Shipping	Grade 2, 2Y.
Det Norske Veritas	Grade 2.
American Bureau of Shipping	AWS A5.1 E6013.

- ▲ General Purpose "XP series" Electrode.
- ▲ Easy Striking - Hot or Cold!
- ▲ Xtra smooth Performance (XP).
- ▲ Versatile - All Positional Capabilities.
- ▲ Ideal for Vertical Down Fillet Welding.
- ▲ All positional fillet welding of steel furniture, plates, fences, gates, pipes and tanks etc.
- ▲ RED flux colour for easy I.D.

**Classifications:**

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

**Packaging and Operating Data:**

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

Electrode Size mm	Length mm	Approx Rods/Kg	Current Range (amps)	Packet	Carton	Easyweld Handipack	Part No
2.0	300	95	40 – 70	2.5kg	15kg – 6 x 2.5kg		612231
2.0	300	95	40 – 70	–	–	90 Rods	322128
2.5	300	55	60 – 100	5kg	15kg – 3 x 5kg		611232
2.5	300	55	60 – 100	2.5kg	15kg – 6 x 2.5kg		612232
2.5	300	55	60 – 100	–	–	50 Rods	322129
3.2	380	30	90 – 130	5kg	15kg – 3 x 5kg		611233
3.2	380	30	90 – 130	2.5kg	15kg – 6 x 2.5kg		612233
3.2	380	30	90 – 130	–	–	25 Rods	322138
4.0	380	19	130 – 180	5kg	15kg – 3 x 5kg		611234

**Easyweld Blister Pack:**

10 x 2.5mm/5 x 3.2mm rod Ferrocraft 12XP Blister Pack	322213
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## MUREX™ SPEEDEX 12

45  
OCV
**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%

- ▲ Speedex™ 12 is a user friendly E4112/E6013 electrode.
- ▲ Ideal for fillet and butt welding in all positions including vertical down.
- ▲ Ideal for the welding of thin steel.
- ▲ Speedex™ 12 produces a quiet smooth arc with low spatter loss.
- ▲ Excellent for misaligned joints.
- ▲ Quick freezing, self detaching slag.
- ▲ Used for welding mild steel, sheet metal, galvanised iron, wrought iron, RHS tubing.
- ▲ Uses for Speedex™ 12 include tanks, gates, trailers, ornamental iron work, back yard projects, frames etc.

**Classifications:**

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

**Packaging and Operating Data:**

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	SP1225
2.5	380	55	55–80	2.5kg	15kg – 6 x 2.5kg	SP12125
3.2	380	30	90–130	5kg	15kg – 3 x 5kg	SP1232
3.2	380	30	90–130	2.5kg	15kg – 6 x 2.5kg	SP12132
4.0	380	19	130–180	5kg	15kg – 3 x 5kg	SP1240