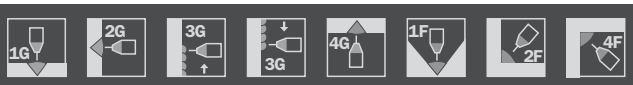
PRODUCT DATA SHEET

WCD 6101

GENERAL PURPOSE ELECTRODES - MILD STEEL

Austarc 12P



SUMMARY

- General Purpose Rutile Type Electrode
- Versatile/All Positional Capabilities Including Vertical Down
- Smooth Performance on Low OCV AC Welding Machines

IDENTIFICATION

Coating - Brown **Tip** - Red **Imprint** - WIA 4313A

CLASSIFICATION

- AS/NZS 4855-B - E43 13 A
- AWS A5.1: E6013

DESCRIPTION AND APPLICATION

Austarc 12P is a smooth running, rutile type electrode for all positional welding of mild steel. It is characterised by a moderately forceful and extremely stable arc. Superb arc starting and restriking on low voltage AC welding machines.

A stiff fast freezing slag for all positional (especially vertical down) fillet welding capabilities. Typical applications include, the all positional welding of galvanised gates/fences, steel furniture, trailers and wrought iron.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
2.5	300	60 - 85	20
3.2	380	90 - 130	21
4.0	380	130 - 180	22

*Recommended for DC +/- or AC (minimum 45 OCV) operation.
**Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guid

SHIPPING APPROVAL

LR 2Ym **ABS** 2 **DNV** 2

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Fe
0.07	0.52	0.32	0.013	0.006	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	450 MPa
Tensile Strength	500 MPa
Elongation	26%
CVN Impact Values	70J @ 0°C

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
2.5	2.5	12.5	64	12P25
3.2	5.0	15	31	12P32
4.0	5.0	15	21	12P40

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