

Inweld 6012

AWS A5.1 E6012

Chemical Composition of Inweld 6012

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.20	0.20	0.30	0.30	1.20	1.00	---	---	0.08	---

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 6012 rutile coated electrodes are used for bridging wide root openings caused by poor fit-up joints on thin sections as well as heavy steel structures. Arc penetration is shallow but easy to handle and forceful enough to prevent slag build-up during vertical down or overhead welding. Weld deposits are fast-freeze and convex shape with smooth evenly spaced ripples when welded in the horizontal position and widely spaced rougher ripples in the vertical position. Common applications include sheet metal, metal furniture, railway freight cars, automobiles, ships, barges, rolling stocks, pipe castings, and tanks.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	60,000 psi
Yield Strength:	48,000 psi
Elongation:	17%

Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.098		50-80
0.13"		80-120
0.16"		120-180

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