



# PRODUCT DATA SHEET

## GENERAL PURPOSE ARC WELDING ELECTRODES

WCD 6101

### AUSTARC 12P



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

#### Identification

**Coating** - Brown

**Tip** - Red

**Imprint** - WIA 4313A

#### Classifications

AS/NZS 1553.1 E4112 Grade O (Superseded)

AWS A5.1 E6013

AS/NZS 4855 ISO 2560B E4313A\*

\*New classification replaces AS/NZS 1553.1

#### Description & Applications

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* (amps)	ARC VOLTAGE RANGE (volts)**
2.0	300	40 - 60	19
2.5	300	60 - 85	20
3.2	380	90 - 130	21
4.0	380	130 - 180	22
5.0	450	180 - 230	23

\* Recommended for DC +/- or AC (minimum 45 OCV) operation.

\*\* Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

#### Approvals

LRS 2M, 2YM

ABS 2

DNV 2

#### Typical All Weld Metal Chemical Analysis

C	Mn	Si	Fe
0.07	0.5	0.3	Bal

#### Typical All Weld Metal Mechanical Properties

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

In as welded condition.

#### Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)			APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton	Minipak		
2.0	2.5	12.5	0.5	103	12P20 12P20M
2.5	2.5	12.5	1.0	67	12P25 12P25M
3.2	3.2	15	1.0	31	12P32 12P32M
4.0	4.0	15	-	20	12P40
5.0	5.0	15	-	11	12P50

#### Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.\*

\*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

#### Issue AB

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