



S. R. Industries

STAR ARC E6012

E6012 is a general purpose electrode that offers excellent bridging characteristics, especially for applications with poor fit-up. It has good, stable arc and operates at high currents with low spatter. Extremely versatile, E6012 can be used with both AC and DC power.

Typical Applications : farm implements, general repair, machinery fabrication, metal furniture, ornamental iron, sheet metal, tanks

AWS Class : E6012	Classification: AWS A5.1/A5.1M:2004
Alloy: E6012	ASME SFA A5.1
Welding Position : F, V, OH, H	Current : AC-DCEN
Tensile Strength, kpsi:	60 min
Yield Strength, kpsi:	48 min
Elongation in 2" (%):	17 min

Typical Wire Chemistry as per AWS A5.1 (single values are maximum)

C	Mn	Si	P	S	Ni	Cr	Mo	V	Combined Limit for Mn+Ni+Cr+Mo+V
0.20	1.20	1.00	*NS	*NS	0.30	0.20	0.30	0.08	*NS

Not Specified

Typical Welding Parameters				
Diameter		Process	Volt	Amps (Flat)
in	(mm)			
3/32	(2.4)	SMAW	19-25	35-100
1/8	(3.2)	SMAW	20-24	90-160
5/32	(4.0)	SMAW	19-23	130-210
3/16	(4.8)	SMAW	18-21	140-250

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