



# Covered Arc Welding Electrode K-6012



### Typical Applications:

Welding of shells of railway vehicles, cars, light vehicles and other steel structures and general light structural steels.

Coating: High titania type

### Characteristics on Usage:

1. Weld metal has a good bead appearance.
2. The electrode diameter less than 3.2mm can be easily used in vertical-down welding.
3. Good X-ray quality.
4. Redry the electrode at 70-100°C for 30-60 minutes prior to use.

### Typical chemical composition of all weld metal (%)

C	Si	Mn	P	S
0.09	0.26	0.46	0.015	0.012

### Typical mechanical properties of all weld metal

Y - P	T - S	EI	Charpy V-notch
N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	%	J (kgf-m) (0degC)
423 (43)	480 (49)	26	90 (9)

### Sizes available, packaging and recommended currents (AC or DC+)

Dia (mm)	2.6	3.2	4.0	5.0	6.0
Length (mm)	350	350	400	400	450
AMP F	50-95	80-120	130-170	180-230	240-300
V & OH	40-95	70-110	100-140	120-160	-----

### Welding Positions:



*Glass  
House  
Specialized  
Supplies*