

CR-12

For welding of steel sheets

AWS A5.1 E6012
KS D 7004 E4313
JIS Z3211 E4313

Applications

Welding of cars, vehicles, machines and general light structural steels.

Characteristics

CR-12 is a high titania type electrode. Its weld metal has a good bead appearance with shallow penetration. It is suitable for welding of steel sheets and general structures.

Notes on usage

- (1) Pay attention not to exceed the range of proper currents. Welding with excessive current not only lowers X-ray soundness, but also causes increase of spatter, undercut and insufficient slag covering.
- (2) Dry the electrodes at 70~100°C for 30~60 minutes before use. Excessive moisture absorption lowers usability and may result in some porosities.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.09	0.34	0.18	0.017	0.011

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %
440(45)	500(51)	26

Size & recommended current range (AC or DC -)

Dia. (mm)	2.0	2.6	2.3	4.0	5.0	6.0	
L (mm)	300	350	350	400	400	450	
Amp.	F	30-65	45-100	85-130	110-160	160-220	210-280
	V&OH	30-65	45-100	85-130	100-150	120-190	-

• Tip Color : Blue