

PRODUCT DATA SHEET

Weldmate GP



Weldmate GP is a low-cost, general-purpose rutile type electrode, suitable for welding mild steel in all positions using AC or DC power sources. Weldmate GP is recommended for welding a wide variety of carbon manganese steels and commercial mild steel.

Applications

Weldmate GP is recommended for welding a wide variety of carbon manganese steels and commercial mild steels having a tensile strength up to approximately 530 MPa.

Technique

Either the touch or free arc technique can be used when welding with Weldmate GP.

Re-drying Procedure

Rutile coated electrodes do not normally require re-drying prior to use, however, if suspected of being damp as shown by an erratic arc behaviour, the electrodes should be re-dried at 100-120°C for 1-2 hours.

Classifications

AWS	A5.1	E6013
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Typical Chemical Analysis (All weld metal)

% Carbon	0,05 - 0,1	% Sulphur	0,025 max
% Manganese	0,35 - 0,6	% Phosphorous	0,025 max
% Silicon	0,2 - 0,5		

Typical Mechanical Properties (All weld metal in the as welded condition)

Yield Strength	370 MPa min
Tensile Strength	460 - 530 MPa
% Elongation on 50 mm	22 min

Packing Data (DC+/- AC 50 OCV min)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
2,5	60 - 95	350	5 x 4,0	W073012
3,15	110 - 130	350	5 x 4,0	W073013
4,0	140 - 165	350	5 x 4,0	W073014

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