

- ▲ General Purpose "XP series" Electrode.
- ▲ Easy Striking - Hot or Cold!
- ▲ Xtra smooth Performance (XP).
- ▲ Versatile - All Positional Capabilities.
- ▲ Ideal for Vertical Down Fillet Welding.
- ▲ RED flux colour for easy I.D.

Classifications:

AS/NZS 1553.1: (old)	E4112-0.
AS/NZS 4855: (new)	B E4313 A
AWS/ASME-SFA A5.1:	E6013.

Description and Applications:

Ferrocraft 12XP is an Xtra smooth Performance (XP) general purpose electrode manufactured at CIGWELD's Welding Consumables Plant. It offers smooth, stable running and superb fillet shapes in all welding positions including vertical-down/up and overhead.

Ferrocraft 12XP is recommended for all your general purpose repair, maintenance and fabrication welding jobs around the home, workshop, farm, fabshop and jobbing shop. It is the ideal vertical-down fillet welding electrode producing a fast freezing viscous slag.

Typical applications of Ferrocraft 12XP include the all positional fillet welding of steel furniture, plates, fences, gates, pipes and tanks etc.

APPROVALS:

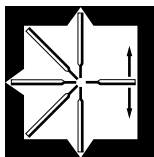
Lloyds Register of Shipping	Grade 2, 2Y.
American Bureau of Shipping	Grade 2, 2Y.
Det Norske Veritas	Grade 2.
American Bureau of Shipping	AWS A5.1 E6013.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	460 MPa
Tensile Strength	540 MPa
Elongation	27%
CVN Impact Values	75J av @ 0°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 0.60%	Si: 0.50%
----------	-----------	-----------



All positional - welding

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx Rods/Kg	Current Range (amps)	Packet	Carton	Hang Tube	Part No
2.0	300	95	40-70	half pack 2.5kg	15kg - 6 x 2.5kg	1 kg	612231
					12kg - 12 x 1kg		322128
2.5	300	55	60-100	5kg	15kg - 3 x 5kg	1kg	611232
2.5	300	55	60-100	half pack 2.5kg	15kg - 6 x 2.5kg		612232
					12kg - 12 x 1kg		322129
3.2	380	30	90-130	5kg	15kg - 3 x 5kg	1kg	611233
3.2	380	30	90-130	half pack 2.5kg	15kg - 6 x 2.5kg		612233
					12kg - 12 x 1kg		322138
4.0	380	19	130-180	5kg	15kg - 3 x 5kg		611234

Blister Pack:

10 x 2.5mm/5 x 3.2mm rod	322213
--------------------------	--------