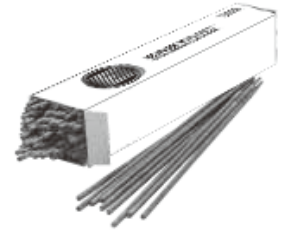


MILD STEEL STICK ELECTRODE

# EASYARC™ 6012



EASYARC™ 6012 is an all positional, rutile electrode for general purpose. EASYARC™ 6012 offers smooth, stable running and superb fillet shapes in all welding positions including vertical-up and overhead.

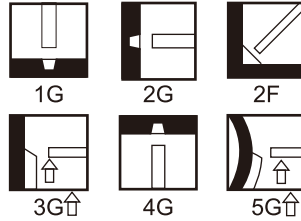
## APPLICATION

EASYARC™ 6012 can be used for the general purpose repair, maintenance and fabrication welding job around the workshop and home, especially for Sheet metal lap and fillet welds. For welding where you require a smooth and clean appearance, the EASYARC™ 6012 electrode is the ideal choice.

## APPROVALS (Pending)

LR

## WELDING POSITIONS



## CONFORMANCE

AWS A5.1: E6012

ASME SFA-5.1: E6012

## GUIDELINES FOR USAGE

- EASYARC™ 6012 electrodes normally do not require reconditioning before use if stored correctly.
- If moisture appears to be a problem, redry electrodes from the opened containers in heated cabinets at 275±75°F (130±20°C) for 60-90 mins.
- Clean the base metal.
- For improved impact properties, avoid use of excessive amperage levels.

## ADVANTAGE LINCOLN

- All position electrode for the welding of mild steel
- Excellent choice for sheet metal lap and fillet welds
- Easy Slag removal
- Superb fast follow characteristics and operation on poor fit-up joints.
- Manufactured under a quality system certified to ISO 9001 requirements.

## PACKING

The EASYARC™ 6012 electrodes are placed inside packets and then sealed in a plastic sleeve. 3 packets of electrodes are then placed inside a carton. For large shipments, the cartons are securely stacked on wooden pallets and covered with shrink-wrap plastic.

## DIAMETERS / PACKAGING

Diameter × Length (mm)	Weight (kg)		Packet per Carton	Pallet Weight (kg)	Product No.
	Packet	Carton			
2.5 x 300	5	15	3	1560	CC011851
3.2 x 350	5	15	3	1620	CC011852
4.0 x 400	5	15	3	1620	CC011853
5.0 x 400	5	15	3	1620	CC011854

## MECHANICAL PROPERTIES --- As welded per AWS A5.1

	Yield Strength Mpa	Tensile Strength Mpa	Elongation (%)	Charpy V-Notch, (Joules)
Required AWS E6012 As-welded	min.330	min.440	min.17	Not Specified
Typical Values As - welded	410	485	26	85@0°C

Charpy V-notch impact tests can exhibit considerable variability depending upon the base plate, welding procedure, V-notch location within the weld, and many other factors. Please contact your Lincoln sales representative for results or recommendations if your application has special requirements or considerations.

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## CHEMICAL COMPOSITION, ALL WELD METAL

	C	Mn	Si	S	P
<b>Requirements AWS E6012 (%)</b>	0.20	1.20	1.00	Not Specified	Not Specified
<b>Typical values (%)</b>	0.07	0.39	0.22	0.016	0.028

## RECOMMENDED WELDING CURRENT(AC, DC+)

Diameter x Length (mm)		2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
Current (A)	Flat	50-80	80-120	150-190	180-240
	Vertical & Overhead	50-80	80-100	110-150	140-200

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn) for any updated information.



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Publication CC1.004.EN Stick Rod  
11/09

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