

GEECON PURPLE (SPL)

IDENTIFICATION

GEECON PURPLE (SPL), E 7016-1

CLASSIFICATION

AWS/SFA5.1: E 7016-1 IS814: EB5626H3 X

DIN: 8529 ESY4276 MnB, EN ISO 2560-A: E38 3 B 12 H10

DESCRIPTION

A heavy coated basic type, hydrogen - controlled, electrode suitable for welding root passes and for bridging wide gaps. The electrode deposits weld metal which is of radiographic quality and meets impact requirements at minus 46°C. The weld deposit is tough, ductile and is highly resistant to hot or cold cracking even when subjected to high stresses, dynamic loading, passes CTOD test at sub-zero temperature when conducted as per relevant specification.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	V	Mn + Cr + Mo + Ni + V
0.1 max	1.0 - 1.60	0.6 max	0.025 Max	0.025 max	0.2 max	0.3 max	0.3 max	0.08 max	1.75 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
500 min	400 min	24 min	Temp	Joules
			-46°C	50 min

TYPICAL APPLICATIONS

- For the welding of structural steel where resistance to brittle fracture is required under adverse operating conditions such as those found in off-shore production platforms.
- Used for production of pressure vessels, bridges, pipelines, etc.

REDRYING TEMPERATURE : 250°C / 2hrs

HARDNESS OF THE WELD METAL : 225 VPN Max

DIFFUSIBLE HYDROGEN : max 5.0ml / 100g of weld metal CTOD **TEST TEMP.:** @ 10° C in accordance with BS7448 Part-II. CTOD VALUE: 0.66- 0.72mm

ASME IX QUALIFICATION : QW - 432 F - NO 4 QW - 442 A - NO 1

CORROSION TEST : Passes corrosion test as per NACE standard TM-01 -77 AND TM -02 -84, GS-8 Annexure 1 of EIL specification.

WELDING POSITION :



PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	65 - 90	2 x 6 = 12	225 x 4 = 900
3.15 / 3.20	450	90 - 140	2 x 6 = 12	120 x 4 = 480
4	450	130 - 180	2 x 6 = 12	70 x 4 = 280
5	450	180 - 240	2 x 6 = 12	55 x 4 = 220