

GRICON 70G

IDENTIFICATION

Gricon 70G, E 7010P1

CLASSIFICATION

AWS/SFA 5.5 E7010P1, EN 499 E382MoC25

DESCRIPTION

Medium coated, all position, cellulosic electrode with a forceful penetrating arc for pipe welding suitable for cross-country pipelines for root, filler and capping passes using down-hand welding technique, weld metal is highly ductile and of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Mo	S	P	Ni	Cr	Mo
0.20 max	1.2 max	0.60 max	0.35 - 0.55	0.025 max	0.03 max	1.0 max	0.30 max	0.50 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
490 min	415 min	22 min	+26°C	60 min
			0°C	50 min
			-30°C	40 min

TYPICAL APPLICATIONS

- Pipe Lines for depositing root run in the in-plant pipe lines.
- For cross-country pipe line, root, filler & capping passes.
- Pipe Steels API TLX-grade 42 - 60.
- Specially suited for pressure pipe lines which cannot be welded from inside.

CURRENT CONDITIONS : DC (+) - FILLER & CAPPING FOR ROOT RUN - DC (+)

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)
2.5	350	60 - 95	2 x 5 = 10
3.15 / 3.20	350	80 - 130	2 x 5 = 10
4	350	110 - 160	2 x 5 = 10
5	350	140 - 190	2 x 5 = 10