

# 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 (%)<br>(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<br>(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            |