

GRICON 75

WELDERS FRIENDLY HEAVY COATED BASIC TYPE, HYDROGEN-CONTROLLED ELECTRODE.

IDENTIFICATION

GRICON 75, E 7015

CLASSIFICATION

AWS A 5.1 E7015

DESCRIPTION

Weld able in all positions (F.H.V.O). Welding technique including arc striking/restricting calls for practical experience for best result. The bead appearance is smooth and the slag is compact, thick and easily detachable. The welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Mn + Ni + Cr + Mo + V
0.1 max	1.25 max	0.9 max	0.03 max	0.03 max	0.3 max	0.2 max	0.3 max	0.08 max	1.50 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
490 min	400 min	24 - 30	27°C	120 - 200
			0°C	100 - 180
			-20°C	80 - 160
			-30°C	60 - 140

TYPICAL APPLICATIONS

- For radiographic quality welding of highly stressed crack sensitive Joints in steel structures, ship building, heavy duty boilers and pressure vessels, bridges, storage tanks, high pressure pipelines etc.
- Recommended for higher carbon & higher sulphur steels, which are susceptible to hydrogen induced cracking.

DIFFUSIBLE HYDROGEN : Max 4ml / 100g of deposited weld metal.

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

REDRYING TEMPERATURE : 250°C / 2hrs

WELDING POSITION :

**PACKING PARAMETERS**

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)
2.5	350	60 - 85	2 x 6 = 12
3.15 / 3.20	450	100 - 130	2 x 6 = 12
4	450	140 - 180	2 x 6 = 12
5	450	180 - 220	2 x 6 = 12