

# 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