

GRICON 76G

IDENTIFICATION

GRICON 76G, E 7016-G

CLASSIFICATION

AWS A5.5 / ASME SFA5.5 E7016-G JIS Z3241 DL5016-6AP1

DESCRIPTION

A basic coated, hydrogen controlled electrode deposits tough and crack free weld metal in butt and fillet joints. The weld metal has very low diffusible hydrogen content and is resistant to ageing. The electrode has an extremely stable arc which enables it to be manipulated in the most difficult positions without any risk of arc extinction due to freezing. The deposited welds meet X-ray quality requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	V	Mn + Cr + Ni + Mo + V
0.09 max	0.90 - 1.40	0.15 - 0.50	0.012 max	0.015 max	0.2 max	0.3 max	0.3 max	0.08 max	1.75 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
500 - 610	425 - 540	24 - 32	-46°C	40 - 120

TYPICAL APPLICATIONS

- For welding structural steels where resistance to brittle fracture is required under adverse operating conditions.
- Off-shore production platforms.
- Fabrication pressure vessels,
- Nuclear containment vessels
- ASTM A106 Grades A, B, C
- ASTM A516 Grades 60, 70
- Bridges, Pipelines, Heavy Machinery, Tanks, Penstocks, etc.

REDRYING TEMPERATURE : 250°C / 2hrs

WELDING POSITION :



1G 2F 2G 3G 4G 5G

PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC (70V) / DC (+)	Packing / Box (kg)
2.5	350	60 - 90	2 x 6 = 12
3.15 / 3.20	450	90 - 140	2 x 6 = 12
4	450	140 - 180	2 x 6 = 12
5	450	180 - 250	2 x 6 = 12