

GRICON GOLD

IDENTIFICATION

GRICON GOLD, E 7024

CLASSIFICATION

AWS: E 7024 IS: 814 1991: ERR-5242-KX BS: E5122RR 14032

DIN : E5122RR1135140

DESCRIPTION

A rutile-coated, iron powder electrode with 140 % deposition efficiency intended for horizontal and fillet welding of heavier section construction steel. Weldable in flat and horizontal positions only. Gives good finish welds and easy slag removal properties. The welding speed is relatively higher. Spatter loss is negligible. Deposition efficiency is approximately 140 %.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.04 - 0.12	0.45 - 0.85	0.25 - 0.45	0.035 max	0.035 max	0.30 max	0.20 max	0.30 max	0.08 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa) (N/mm ²)	YS (MPa) (N/mm ²)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
500 - 600	430 - 520	22 - 28	0°C	48 - 85

TYPICAL APPLICATIONS

Heavy Structural steel works, ship building, boilers, high pressure vessels, bridges, storage tanks, railway wagons & coaches, heavy machinery, earth moving equipments, specially issued for building up and finishing run. Structural steel plate upto moderate thickness upto 20 mm max.

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

REDRYING TEMPERATURE : If moist, 100 - 120°C / 1 -2 hrs.

WELDING POSITION :



1G



2F



2G

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (-)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	70 - 105	5 x 4 = 20	120 x 4 = 480

3.15 / 3.20	450	100 - 140	5 x 4 = 20	80 x 4 = 320
4	450	170 - 200	5 x 4 = 20	45 x 4 = 180
5	450	200 - 250	5 x 4 = 20	30 x 4 = 120