

# GRICON GREEN MDH

## IDENTIFICATION

GRICON GREEN MDH, E 7018-1

## CLASSIFICATION

AWS/SFA5.1: E7018-1 IS814: EB5626H3 JX,  
BS: E5155B (11026H) DIN: 5155B1029

## DESCRIPTION

A heavy coated basic type, hydrogen - controlled, iron powder electrode with high deposition efficiency. The electrode deposits weld metal, which is of radiographic quality and meets impact requirements at minus 50°C. The weld deposit is tough, ductile and is highly resistant to hot or cold cracking even when subjected to high stresses, dynamic loading etc. The deposited weld metal has resistance to ageing hence it is used for critical application in steel plants.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	V	Mn + Cr + Mo + N + V
0.08 max	1.20 - 1.60	0.45 max	0.015 max	0.015 max	0.1 max	0.15 max	0.15 max	0.08 max	1.75 max

## MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
500 - 600	440 - 540	24 - 30	-50°C	100 - 150

## TYPICAL APPLICATIONS

- For fabrication of critical parts of steel melting shop such as Ladle, off-shore production platforms.
- Used for production of pressure vessels, bridges, pipelines, etc.

**REDRYING TEMPERATURE :** 300°C / 2hrs

**DIFFUSIBLE HYDROGEN :** max 4.0ml / 100g of weld metal in the weld metal

**HARDNESS OF THE WELD METAL :** 200 Brinell max

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

## WELDING POSITION :



## PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
-----------	-------------	------------------	--------------------	---------------------

2.5	350	65 - 85	2 x 6 = 12	150 x 4 = 600
3.15 / 3.20	450	110 - 140	2 x 6 = 12	100 x 4 = 400
4	450	140 - 180	2 x 6 = 12	65 x 4 = 260
5	450	180 - 240	2 x 6 = 12	45 x 4 = 180