

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 |