

GRICON GREEN NC

IDENTIFICATION

GRICON GREEN NC, E 7018-1

CLASSIFICATION

AWS/SFA 5.1 E7018-1, DIN 8529

ESY 4276MU8 DIN EN 499 E426B42H5 BS639-86 E5143B(24H)

DESCRIPTION

A basic coated, hydrogen controlled electrode deposits tough and crack free weld metal in butt and fillet joints. The weld metal has a 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 + 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)	YS (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

HARDNESS OF THE WELD METAL : 22 RC MAX

DIFFUSIBLE HYDROGEN IN THE WELD METAL : 4ml max / 100g of weld metal

CORROSION TEST : Passes corrosion test as per NACE standard TM-01-77 AND TM-02-84, GS-8

CURRENT CONDITIONS : AC (70V) or DC (+)

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (70V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	2 x 6 = 12	150 x 4 = 600
3.15 / 3.20	350	90 - 140	2 x 6 = 12	100 x 4 = 400
3.15 / 3.20	450	90 - 140	2 x 6 = 12	100 x 4 = 400
4	350	140 - 180	2 x 6 = 12	65 x 4 = 260
4	450	140 - 180	2 x 6 = 12	65 x 4 = 260
5	450	180 - 250	2 x 6 = 12	45 x 4 = 180