

GRICON GREEN (SPL) H4R

IDENTIFICATION

GRICON GREEN (SPL) H4R, E 7018-1 H4R

CLASSIFICATION

AWS/SFA 5.1: E 7018-1 H4R, BS: E5155B (11026H),
DIN: 5155B1029 EN ISO 2560-A E465B32H5

APPROVALS : ABS, DNV-GL, LRS, BV, CE, KNPC, KOC, HPCL, NTPC, IOCL, IOTL, HPCL, EIL.

DESCRIPTION

A heavy coated basic type, hydrogen - controlled, iron powder electrode with high deposition efficiency 112%. The electrode deposits weld metal, which is of radiographic quality and meets impact requirements at minus 50°C.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	V	Mn + Cr + Mo + Ni + V
0.1 max	1.0-1.55	0.55 max	0.025 Max	0.025 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 - 650	440 - 540	24 - 32	-20°C	120
			-50°C	50
			-45°C	50

TYPICAL APPLICATIONS

- For shipbuilding.
- For the welding of structural steel where resistance to brittle fracture is required under adverse operating conditions such as those found in off-shore production platforms.
- Used for production of pressure vessels, bridges, pipelines recommended for higher carbon & higher Sulphur steels, which are susceptible to hydrogen induced cracking.

REDRYING TEMPERATURE : 300°C / 2hrs

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

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

WELDING POSITION :



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

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	350 / 450	110 - 140	2 x 6 = 12	100 x 4 = 400
4	350 / 450	140 - 180	2 x 6 = 12	65 x 4 = 260
5	450	180 - 240	2 x 6 = 12	65 x 4 = 260