GWELD
SEAL OF TRUST

GRICON GREEN (SPL)

IDENTIFICATION
GRICON GREEN (SPL), E 7018-1

CLASSIFICATION
AWS/SFA 5.1: E7018-1, IS 814: 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. The weld deposit is tough, ductile and is highly resistant to hot or cold cracking even when subjected to high stresses, dynamic loading etc.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	V	Mn + Cr + Mo + Ni + V
0.1 max	1.0 - 1.60	0.45 max	0.025 max	0.025 max	0.2 max	0.3 max	0.3 max	0.08 max	1.75 max

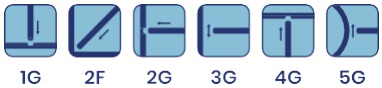
MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
500 - 600	440 - 540	24 - 30	-46oC	50 - 150
			-50oC	50 - 120

TYPICAL APPLICATIONS
- 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.
- For welding SAILMA 350HI steel.

REDRYING TEMPERATURE : 250o C/ 2hrs
DIFFUSIBLE HYDROGEN : Max 5.0ml/100g of weld metal in the weld metal
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