

GRICON GREEN

IDENTIFICATION

GRICON GREEN, E 7018

CLASSIFICATION

AWS/SFA 5.1: E7018, IS 814: EB5426H3JX, DIN: 5144B1026

DESCRIPTION

Welder's friendly heavy coated basic type, hydrogen-controlled, iron powder electrode with high deposition efficiency.

- Weld able in all positions (F.H.V.O). Welding technique including arc striking / restricting calls for practical experience for best result.
- The bead appearance is smooth and the slag is compact, thick and easily detachable. Deposition efficiency of weld metal is approx. 115%. The welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Mn + Ni + Cr + Mo + V
0.1 max	0.80 - 1.60	0.75 max	0.03 max	0.03 max	0.3 max	0.2 max	0.3 max	0.08 max	1.75 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
510 min	440 min	24 - 30	Temp	Joules
			27°C	120 - 200
			0°C	100 - 180
			-20°C	80 - 160
			-30°C	60 - 140

TYPICAL APPLICATIONS

- For radiographic quality welding of highly stressed crack sensitive Joints in steel structures, ship building, heavy duty boilers and pressure vessels, bridges, storage tanks, high pressure pipelines etc.
- Recommended for higher carbon & higher sulphur steels, which are susceptible to hydrogen induced cracking.

REDRYING TEMPERATURE : 250°C / 2hrs

DIFFUSIBLE HYDROGEN : max 4ml / 100g of deposited weld metal.

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

MOISTURE CONTENT IN THE FLUX COATING : 0.40% max

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (70 OCV) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 85	2 x 6 = 12	150 x 4 = 600
3.15 / 3.20	450	100 - 130	2 x 6 = 12	100 x 4 = 400
4	450	130 - 180	2 x 6 = 12	65 x 4 = 260
5	450	180 - 220	2 x 6 = 12	65 x 4 = 260