

GRICON LILAC

IDENTIFICATION

Gricon Lilac, E 6018

CLASSIFICATION

AWS A 5.1 E6018

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.112%.The welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Mn + Ni + Cr + Mo + V
0.08 max	0.5 - 0.9	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)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
450 - 550	360 - 460	22 - 28	27°C	120 - 200
			0°C	100 - 180
			-20°C	80 - 160
			-20°C	60 - 140

TYPICAL APPLICATIONS

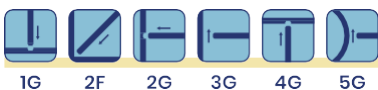
For radiographic quality welding of highly stressed crack sensitive joints in steel structures, ship building, heavy duty boilers and pressure vessels, bridges, storage tanks, high pressure pipelines etc. Recommended for higher carbon & higher sulphur steels, which are susceptible to hydrogen induced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

WELDING POSITION :



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

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+/-)	Packing / Box (Pcs)
2.5	350	65 - 100	240 x 4 = 960
3.15 / 3.20	350	80 - 135	150 x 4 = 600
4	450	120 - 175	90 x 4 = 360
5	450	150 - 210	60 x 4 = 240