GWELD
SEAL OF TRUST

GRIDUCT 100

IDENTIFICATION
Griduct 100, E 8018-G

CLASSIFICATION
AWS/SFA 5.5: E8018G

DESCRIPTION
Basic coated, hydrogen controlled, iron powder electrode depositing weld metal containing about 1.2% Mn and 2.1% Ni.The electrode is specially recommended for welding thick sections of fine grained, high tensile low temperature steels. The weld metal gives excellent impact strength down to minus 50°C. Deposited welds are of radiographic quality. Weld deposit is of extremely high metallurgical purity & very low hydrogen content.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Mo
0.08 max	0.70 - 1.40	0.20 - 0.55	0.015 max	0.020 max	1.90 - 2.60	0.15 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
			Temp	Joules
600 min	500 min	22.0 min	-50°C	50 min

TYPICAL APPLICATIONS
- For welding DMR 249 A steel.
- Welding of fine grained steels for pressure vessels, tanks, penstocks, where high strength & sub subzero temperature toughness properties are of importance.
- For fabrication of hull, medium tensile steel.
- For shipbuilding and repair.

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : 4.0 ml / 100g maximum
REDRYING TEMPERATURE : 400°C / 2 hrs.

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	70 - 100	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	100 - 140	5 x 4 = 20	110 x 4 = 440
4	450	140 - 190	5 x 4 = 20	70 x 4 = 280
5	450	180 - 240	5 x 4 = 20	45 x 4 = 180