

GRIDUCT 108G

IDENTIFICATION

Griduct 108G, E 10018-G

CLASSIFICATION

AWS/SFA 5.5: E 10018G

DESCRIPTION

An extruded heavy coated Hydrogen controlled Low-alloy, High Tensile Electrode. The electrode works in all position gives very little spatter with an easily removable slag leaving a bead of nice appearance. The deposition efficiency is approx. 110%.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo
0.09 max	1.3 - 1.8	0.5 max	0.020 max	0.020 max	1.7 - 2.30	0.25 max	0.20 - 0.40

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
690 - 780	620 min	20 min	27°C	157
			-40°C	45

TYPICAL APPLICATIONS

- For Welding API 5L-grade X-70 and X-80 Penstock, earth moving equipments and heavy steel Fabrications made from High tensile steel.
- Excellent for welding fully killed fine Grained steels.
- Welding High Tensile steel SUMITEN 690
- Used for penstocks.

WELDING PROCEDURE

Use short arc length. Weaving of electrodes, if necessary should be done at slow speed and keeping a short arc. The electrodes should be used in perfectly dry condition. The electrodes should be dried at 400°C for 1 hour to obtain better result. Maintain interpass temperature below 120°C.

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : 2.0ml / 100g of deposited weld metal, Maximum.

WELDING POSITION :



PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC (90V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 85	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	90 - 130	5 x 4 = 20	110 x 4 = 440
4	450	140 - 190	5 x 4 = 20	70 x 4 = 280
5	450	190 - 250	5 x 4 = 20	45 x 4 = 180