GWELD
SEAL OF TRUST

GRIDUCT 108M

IDENTIFICATION
Griduct 108M, E 10018M

CLASSIFICATION
AWS/SFA 5.5: E 10018M

DESCRIPTION
A basic 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 deposited welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.09 max	1.0 - 1.7	0.6 max	0.02 max	0.02 max	1.4 - 2.1	0.20 - 0.35	0.25 - 0.50	0.05 max

MECHANICAL PROPERTIES (RANGE)

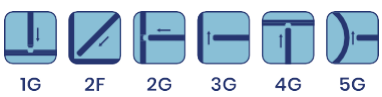
TS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
690 - 795	610 - 690	20 - 26	-51°C	27 - 70

TYPICAL APPLICATIONS
- Penstock, earth moving equipments and heavy steel.
- Fabrications made from high tensile steel.
- For welding USS-T1 steel, N-A-XTRA 63 &70, H SBB77V

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. Maintain interpass temperature between 100 - 140°C.

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : 3.0ml / 100g of deposited weld metal, Maximum
REDRY AT : 350 - 400°C / for 2 hrs.

WELDING POSITION :



PACKING PARAMETERS

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