

# GRIDUCT 118M

## IDENTIFICATION

Griduct 118M, E 11018M

## CLASSIFICATION

AWS : E11018M IS: E76BM329Fe

DIN : 8529-81~ EY 6977 Mn2NiMoBH5 BS : 2493-85 2NiMOB

## DESCRIPTION

A basic coated Hydrogen controlled Low-alloy, High Tensile Electrode. The weld metal combines very high strength properties with good fracture toughness at temperature down to minus 51°C.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.09 max	1.3 - 1.8	0.5 max	0.020 max	0.020 max	1.4 - 2.50	0.25 - 0.40	0.25 - 0.50	0.05 max

## MECHANICAL PROPERTIES (RANGE)

TS (N/mm <sup>2</sup> )	YS (N/mm <sup>2</sup> )	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
760 - 840	680 - 760	20 min		
			27°C	120 - 180
			-51°C	27 - 60

## TYPICAL APPLICATIONS

- Specially recommended for welding ASTM A517 Gr F Q&T steel. Excellent for welding fully killed fine grained steels. The electrode works in all position gives very little spatter with an easily removable slag leaving a bead of nice appearance. The electrodes should be redried at 350 - 400°C for 2 hours to obtain better result.
- Penstock, earth moving equipments and heavy steel Fabrications made from high tensile steel. For welding USS -T1 steel, WEL -TEN 80 steels, SA 517 grade F and their equivalents.

## 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 below 120°C.

**DIFFUSIBLE HYDROGEN CONTENT** : 2.0ml / 100g of deposited weld metal. (Typical) in the weld metal

## WELDING POSITION :



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

**PACKING PARAMETERS**

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<b>Size (mm)</b>	<b>Length (mm)</b>	<b>Amps AC (90V) / DC (+)</b>	<b>Packing / Box (kg)</b>	<b>Packing / Box (Pcs)</b>
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