

# GRIDUCT 125G

## IDENTIFICATION

Griduct 125G, E 12015G

## CLASSIFICATION

AWS/SFA 5.5 E12015G

## DESCRIPTION

Basic coated, ultra low hydrogen high tensile low alloy steel electrode suitable for welding high tensile, fully killed fine grained low alloy steel. The electrode deposits X-ray / ultrasonic quality weld metal and can be used in all positions.

## WELD METAL ANALYSIS (RANGE) %

C	Cr	Mn	Si	S	Ni	Mo	P	V
0.095 max	0.30 - 0.75	1.30 - 1.90	0.20 - 0.50	0.020 max	1.70 - 2.60	0.20 - 0.60	0.025 max	0.05 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
850 min	750 min	16 min	20°C	30 average

## TYPICAL APPLICATIONS

- For fabrication of penstocks, earthmoving equipments, cranes and other heavy steel fabrication made from high tensile steels.
- Suitable for welding HY 80 and HY 100 steels, Q1 (N) submarine components cranes highly stressed plants.

**DRYING OF THE ELECTRODES :** 300 - 350°C / 2 hrs.

**ASME IX QUALIFICATION :** QW-432 F Number: 4, QW-442 A Number: 10

**DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL :** Max. 3.0 ml / 100 g. of weld metal.

## WELDING POSITION :



## PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	70 - 110	5 x 4 = 20	110 x 4 = 440
4	450	100 - 155	5 x 4 = 20	70 x 4 = 280
5	450	150 - 200	5 x 4 = 20	45 x 4 = 180