

GRIDUCT 126G

IDENTIFICATION

Griduct 126G, E 12016G

CLASSIFICATION

AWS/SFA 5.5 E12016G

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
0.10 Max	0.30- 0.75	1.30- 1.80	0.25- 0.75	0.020 max	1.70-2.50	0.20-0.50	0.025 max	0.05 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPA)	YS (MPa)	ELN (%) (L=4D)	CVN Impact strength Temp.	Joules
830 Min	740 Min	-51°C	-51°C	30 Min

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: 300-350oC / 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.

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS DC(+)	PACKING/CARTON (KG.)
2.50	350	60-80	2 x 5 = 10

3.15	450	70-110	2 x 5 = 10
4.00	450	100-155	2 x 5 = 10
5.00	450	150-200	2 x 5 = 10