

GRIDUCT 128G

IDENTIFICATION

Griduct 128G, E 12018G

CLASSIFICATION

AWS/SFA 5.5 E12018G

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 - 1.80	0.20 - 0.50	0.020 max	1.70 - 2.50	0.20 - 0.50	0.025 max	0.05 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm ²)	YS (N/mm ²)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
850 - 950	720 - 800	16 - 22	-51°C	30 - 75

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