

GRIDUCT 128M

IDENTIFICATION

Griduct 128M, E 12018M

CLASSIFICATION

AWS/SFA 5.5: E12018M

DESCRIPTION

Basic coated Hydrogen controlled Low-alloy, High Tensile Electrode. The deposition efficiency is approx. 110%. Deposited welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

| C | Mn | Si | S | P | Ni | Cr | Mo | V |
|----------|------------|---------|-----------|-----------|-------------|-------------|-------------|----------|
| 0.09 max | 1.3 - 2.25 | 0.6 max | 0.020 max | 0.020 max | 1.75 - 2.50 | 0.30 - 1.50 | 0.30 - 0.55 | 0.05 max |

MECHANICAL PROPERTIES (RANGE)

| TS (MPa) | YS (MPa) | EL (%) (L=4D) | CVN Impact Value | |
|-----------|-----------|------------------|------------------|---------|
| | | | Temp | Joules |
| 830 - 980 | 745 - 830 | 18 min | 27°C | 150 |
| | | | -51°C | 27 - 80 |

TYPICAL APPLICATIONS

- Penstock, earth moving equipments.
- Heat treated fine grained steels.
- For welding USS -T1 steel, WEL -TEN 80 steels, HY 100 equivalents. Specially recommended for welding ASTM AS17Gr F Q&T steel.

WELDING PROCEDURE : Use short arc length. The electrodes should be used in perfectly dry condition. The electrodes should be dried at 400°C for 1 to 2 hours to obtain better result.

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : Max. 4.0 ml / 100 g max of deposited weld metal.

WELDING POSITION :



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

PACKING PARAMETERS

| Size (mm) | Length (mm) | Amps | Packing / Box (kg) | Packing / Box (Pcs) |
|-------------|-------------|-------------------|--------------------|---------------------|
| | | AC (90V) / DC (+) | | |
| 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 |

