GWELD
SEAL OF TRUST

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 :

PACKING PARAMETERS

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