

GRIDUCT 138G

IDENTIFICATION

Griduct 138G, E 12018G

CLASSIFICATION

AWS/SFA 5.5 : E12018G,

DIN EN 757 E894 Mn2 Ni1 Cr Mo B42 H5

DESCRIPTION

Heavy coated, hydrogen controlled, all-position electrode depositing, tough and crack free welded joints. Weld deposits is of extremely high purity and very low hydrogen content. Deposited welds are of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Cr	S	Mn	Ni	Si	Mo	P	V
0.06 max	0.70 max	0.015 max	1.65 max	2.40 max	0.48 max	0.50 max	0.015 max	0.02 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
950 min	890 min	14 - 20	27°C	70 - 150
			-40°C	70 min

TYPICAL APPLICATIONS

- For welding Q & T high tensile steels type HY 130 and equivalent Normalised+tempered five grain structural steels with yield stress up to 900 MPa.
- For welding BRINAR 400 / DILLIDUR 400 steel.

SPECIAL INSTRUCTIONS FOR WELDING

- Maintain preheat & interpass temperature in the range 100-120°C.
- Use lower dia electrode with minimum heat in-put to get desired structure & mechanical properties.
- When welding is completed, maintain temperature of 200-250°C for 4-6 hours for removing Diffusible Hydrogen from HAZ and weld metal.

REDRYING OF ELECTRODES : 300-350°C / 2 hrs.

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

WELDING POSITION :



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

PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC (70 OCV) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	65 -95	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	90 - 135	5 x 4 = 20	110 x 4 = 440
4	450	140 - 185	5 x 4 = 20	70 x 4 = 280
5	450	180 - 240	5 x 4 = 20	45 x 4 = 180