

GRIDUCT 200

IDENTIFICATION

Griduct 200, E 10018-G

CLASSIFICATION

AWS/SFA 5.5 :E 10018-G

DESCRIPTION

Basic coated, hydrogen controlled, iron powder electrode depositing weld metal containing about 1.4% Mn and 2.0% Ni. The electrode is specially recommended for welding thick sections of fine grained, high tensile low temperature steels. The weld metal gives excellent impact strength down to minus 50°C. Deposited welds are of radiographic quality. Weld deposit is of extremely high metallurgical purity & very low hydrogen content.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Mo	Cr
0.08 max	1.0 - 1.70	0.20 - 0.55	0.015 max	0.020 max	1.40 - 2.60	0.20- 0.45	0.35 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
			Temp	Joules
650 min	590 min	20 - 26	-50°C	50 - 125

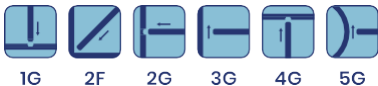
TYPICAL APPLICATIONS

- For welding DMR 249 B steel.
- Welding of fine grained steels for pressure vessels, tanks, penstocks, where high strength & subzero temperature toughness properties are of importance.
- For construction of submarines etc.

DIFFUSIBLE HYDROGEN CONTENT : 3.0 ml / 100 g. deposited metal (maximum)

REDRYING TEMPERATURE : 400°C / 2 hrs

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	70 - 100	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	90 - 140	5 x 4 = 20	110 x 4 = 440
4	450	130 - 180	5 x 4 = 20	70 x 4 = 280

