

GRIDUCT 300

IDENTIFICATION

Griduct 200, E 9018-G

CLASSIFICATION

AWS/SFA 5.5: E 11018G

DESCRIPTION

Basic coated hydrogen controlled electrode depositing weld metal having tensile strength more than 760 MPa. The welds are of radiographic quality and electrode can be used as all positions except vertical down.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	V
0.05 - 0.08	1.40 - 1.80	0.20 - 0.50	0.012 max	0.015 max	0.20 - 0.40	1.80 - 2.40	0.30 - 0.55	0.05 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
			Temp	Joules
760 min	690 min	18 min	-50°C	50 min

TYPICAL APPLICATIONS

Welding of high tensile Q & T steels such as US T-1, HY80, A517 Gr B and F and equivalents.

DIFFUSIBLE HYDROGEN CONTENT : ≤ 3.0ml / 100g

DRYING TEMPERATURE : 425° - 450°C / 1 to 2 hrs

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