

GRIDUCT 400

IDENTIFICATION

Griduct 400, E 12018-G

CLASSIFICATION

AWS/SFA 5.5: E 12018G

DESCRIPTION

Basic coated hydrogen controlled electrode depositing weld metal having tensile strength more than 850 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	1.50 - 1.90	0.20 - 0.50	0.012 max	0.015 max	0.25 - 0.45	1.90 - 2.50	0.30 - 0.55	0.05 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
			Temp	Joules
850 min	760 min	15 min	-40°C	50 min
			-50°C	45 min

TYPICAL APPLICATIONS

Welding of high tensile Q & T steels such as US T-1, HY80, HY 100 , A517 Gr B and F and equivalents.

DIFFUSIBLE HYDROGEN CONTENT : ≤ 3.0ml / 100g

DRYING TEMPERATURE : 425° - 450°C / 2 hrs min

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps 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