

# 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