

GRIDUCT 5350

IDENTIFICATION

Griduct 5350

DESCRIPTION

A special basic coated hydrogen controlled electrode depositing low-alloy steel weld metal which possesses excellent resistance to heat. Electrode deposits weld metal which is free from cracks and can withstand heavy impact and heat.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	Cr	Ni	Mo	V
0.080 - 0.13	1.30 - 1.85	0.35 - 0.60	0.03 max	2.8 - 3.3	1.8 - 2.3	1.25 - 1.50	0.24 - 0.36

TYPICAL APPLICATIONS

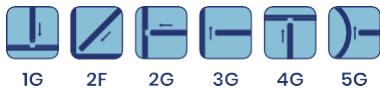
- Surfacing/rebuilding hot forging dies
- Repairing hot working tools
- Surfacing hammer dies etc.

PRECAUTIONS / SPECIAL INSTRUCTIONS WHILE WELDING

- Dry the electrodes at 300 °C/2 hrs
- Preheat the job-preheating temperature depending on the type of die
- Use short arc.

HARDNESS OF THE WELD METAL (3 LAYERS) : 41 HRC approx

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC 70 (OCV) / 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	100 - 140	5 x 4 = 20	110 x 4 = 440
4	450	140 - 180	5 x 4 = 20	70 x 4 = 280
5	450	180 - 230	5 x 4 = 20	45 x 4 = 180