

GRIDUCT 6

IDENTIFICATION

Griduct 6, E 8018-G

CLASSIFICATION

AWS/SFA 5.5: E 8018G

DESCRIPTION

An extruded heavy coated Nickel Manganese alloyed, low hydrogen, Iron Powder electrode for welding High Tensile and Low Alloy Steels. Deposited welds are radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni
0.09 max	1.2 - 1.8 max	0.5 max	0.03 max	0.03 max	0.5 - 1.0

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
570 - 690	470 - 530	22 - 27	27°C	157
			0°C	120
			-20°C	100
			-40°C	80
			-60°C	34

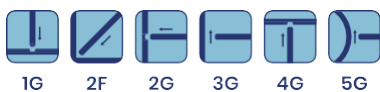
TYPICAL APPLICATIONS

For welding fine-grained construction steels, heavy sections, and low alloy steels, High-pressure vessels, storage tanks, pipelines chemical industries.

WELDING PROCEDURE:

Use short arc length. Weaving of electrodes, if necessary should be done at slow speed and keeping a short arc. The electrodes should be used in perfectly dry condition. Redry electrodes at 300-350° C for one hour.

WELDING POSITION :



1G 2F 2G 3G 4G 5G

PACKING PARAMETERS

GWELD

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