

GRIDUCT 60

IDENTIFICATION

Griduct 60, E 8018-G

CLASSIFICATION

AWS/SFA 5.5: E 8018G IS: E55BG129Fe

DESCRIPTION

An extruded basic coated Nickel Manganese alloyed, low hydrogen, iron powder electrode for welding high tensile and low alloy steels. Weldable in all positions except vertical down. Deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Mo
0.05 - 0.10	1.00 - 1.60	0.30 - 0.75	0.02 max	0.02 max	0.40 - 0.80	0.05 - 0.30

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 min	460 min	22 min	-40°C	47

TYPICAL APPLICATIONS

- For welding Boiler pressure parts of SA 299, A 299 GR- B material, IS 8500 GR 540.
- For X-ray quality welding of very highly stressed joints. For welding fine-grained construction steels, heavy sections, and low alloy steels. High-pressure vessels, storage tanks, pipelines chemical industries, etc.
- Excellent for welding Nickel-alloyed steels up to 1.0% Nickel.

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : Max 5ml / 100ms

REDRYING TEMPERATURE : 300°C / 2 hrs

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (90V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	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	130 - 180	5 x 4 = 20	70 x 4 = 280
5	450	180 - 240	5 x 4 = 20	45 x 4 = 180