

# GRIDUCT 7

## IDENTIFICATION

Griduct 7, E 10016G

## CLASSIFICATION

AWS/SFA 5.5: E 10016G

## DESCRIPTION

An extruded heavy coated, Low Hydrogen type electrode for all position welding of Low alloy high tensile steels. The deposited weld metal is of radiographic quality.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo
0.09 max	1.0 - 1.70	0.2 - 0.6	0.03 max	0.03 max	1.0 - 1.8	0.4 max	0.40 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
690 - 790	640 min	18 min	27°C	50 - 100

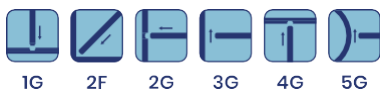
## TYPICAL APPLICATIONS

- Ideal for welding of pressure vessels high-tensile steel machinery parts, earthmoving equipment parts, automobile parts, chemical plant equipments, steam turbine, rotors, etc.
- Suitable for machinery parts made of high tensile and low alloy steels and essential steel structures using for 70 Kgf/mm<sup>2</sup> class steels for welding N-A-XTRA 60 Steel.
- Use short arc length.

**DIFFUSIBLE HYDROGEN IN THE WELD METAL :** less than 4ml / 100g of weld metal.

**REDRYING TEMPERATURE :** 350°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 - 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