

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/mm² 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