GWELD
SEAL OF TRUST

GRIDUCT 75B2L

IDENTIFICATION
Griduct 75B2L, E 7015B2L

CLASSIFICATION
AWS A5.5: E 7015 B2L

DESCRIPTION
A heavy coated, basic type, low hydrogen all-position, except vertical down, electrode, which deposits 1.25% Cr / 0.5% Mo weld metal. The electrode is synthetic type and is intended for welding creep resisting steels of similar composition, used in power generating plant operating at temperatures upto 570°C.The welds are of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo
0.050 max	0.5 - 0.9	0.2 - 0.6	0.02 max	0.03 max	1.0 - 1.50	0.4 - 0.65

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
530 min	425 min	19 - 26	**Temp**	**Joules**
			-20°C	40 min

TYPICAL APPLICATIONS

ASTM A 335 grades P11 and P12 ASTM A 155 grades ½ C, 1 Cr, 1 ¼ Cr, A182F11, DIN 13 CrMo44, GS-17CrMo55, BS 3604 grades 620 and 621. Ideal for welding Chromium-Molybdenum alloy steels (0.5Cr-0.5Mo, Icr-0.5Mo, 1.25Cr-0.5Mo), boilers, pressure vessels, headers, high pressure piping, heat exchangers and condensers, power generation, oil refineries, petrochemical 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.

ASME QUALIFICATION : QW – 432 F. NO4, QW - 442 A NO.4

RECOMMENDED REDRYING : 300°C / 2 hrs, (Max. 5 times, and total 10 hrs max.)

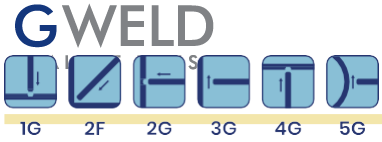
RECOMMENDED PREHEAT & INTERPASS TEMP. : 165°C - 190°C

MOISTURE IN THE FLUX COATING : 0.3% by weight, maximum

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : Max 5 ml / 100 gm of weld metal

MICROSTRUCTURE : After PWHT, the microstructure consists of tempered bainite.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (70V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	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