

# 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	
			Temp	Joules
530 min	425 min	19 - 26	-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, 1Cr-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