

GRIDUCT 8

IDENTIFICATION

Griduct 8, E 11018-G

CLASSIFICATION

AWS/SFA 5.5 : E 11018G

DESCRIPTION

An extruded low hydrogen, Iron powder type electrodes for welding high strength steels. Weldable in all positions except vertical down. Striking and restriking properties are good with little spatter and easy to remove slag.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Ni	Mo	Cr	S	P
0.09 max	1.0 - 1.80	0.60 max	1.8 - 2.70	0.25 - 0.55	0.35 max	0.030 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
760 min	690 min	15 min	-40°C	30 min

TYPICAL APPLICATIONS

- Ideally suitable for welding of high strength steels, fine grained steels, HSLA, Q & T steels, etc.
- Ideal for welding high strength steel for earth moving Industry.

WELDING PROCEDURE:

Use short arc length and stringer bead. Electrode should be in perfectly dry condition.

REDRYING TEMPERATURE : 300°C / 1 hr

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