

# GRIDUCT 80G

## IDENTIFICATION

Gricon 80G, E 8010P1

## CLASSIFICATION

AWS/ SFA 5.5 E8010P1 EN 499 E 382MoC25

## DESCRIPTION

Medium coated, cellusic electrode with a forceful penetrating arc for pipe welding suitable for cross-country pipelines for root, filler and capping passes using down-hand welding technique, weld metal is highly ductile and of X-ray quality.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Mo	S	P	Ni	Cr
0.20 max	1.20 max	0.60 max	0.50 max	0.025 max	0.03 max	1.0 max	0.30 max

## MECHANICAL PROPERTIES (RANGE)

TS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 min	460 min	19 min	+26°C	60 min
			0°C	50 min
			-30°C	40 min

## TYPICAL APPLICATIONS

- Pipe Lines for depositing root run in the in-plant pipe lines.
- For cross-country pipe line, root, filler & capping passes.
- Pipe Steels API TLX-grade 42 - 60.
- Specially suited for pressure pipe lines which cannot be welded from inside.

**CURRENT CONDITIONS :** DC (+) - FILLER & CAPPING FOR ROOT RUN - DC (+)

## WELDING POSITION :



## PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)
2.5	350	60 - 95	5 x 4 = 20
3.15 / 3.20	350	80 - 130	5 x 4 = 20
4	350	110 - 160	5 x 4 = 20
5	350	140 - 190	5 x 4 = 20