GWELD
SEAL OF TRUST

GRIDUCT 85B6L

IDENTIFICATION
Griduct 85B6L, E 8015-B6L

CLASSIFICATION
AWS/SFA 5.5: E 8015-B6L

DESCRIPTION
Hydrogen controlled, heavy coated, basic type electrode depositing extra low carbon 4.0% Cr / 0.50 Mo weld metal. It is intended for welding creep resisting steels of similar composition used in steam generation plant operating at temperature up to 600°C. The weld deposit meets x-ray / radiographic quality requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo
0.05 max	0.4 - 1.0	0.2 - 0.6	0.025 max	0.03 max	4.0 - 6.0	0.45 - 0.65

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 min	460 min	19 min	-30°C	27 min

TYPICAL APPLICATIONS
- ASTM A 199, A 200,
- A 213 Grade T22, T36 & T4
- A 182 F 22
- A 387 Grade D
- A 217 WC9
- A 335 Grade P 22, P5B
- Chemical and Petrochemical industries where resistance to hydrogen attack, corrosion from sulphur bearing crude oil and stress corrosion cracking in sour atmosphere is required.

REDRYING TEMPERATURE FOR ELECTRODES : 300°C / 1 hr
MICROSTRUCTURE : In PWHT condition, the microstructure consists of tempered bainite
ASME IX QUALIFICATION : QW 432 F - NO, QW 442 A- NO 4

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	5 x 4 = 20	160 x 4 = 640

3.15 / 3.20	450	90 - 140	5 x 4 = 20	110 x 4 = 440
4	450	130 - 180	5 x 4 = 20	70 x 4 = 280
5	450	160 - 220	5 x 4 = 20	45 x 4 = 180