

# GRIDUCT 85B8

## IDENTIFICATION

Griduct 85B8, E 8015-B8

## CLASSIFICATION

AWS/SFA 5.5: E 8015-B8

## DESCRIPTION

A heavy basic coated type hydrogen controlled, all position iron powder Chrome-moly medium alloy electrode for elevated temperature applications. The deposited weld metal is of radiographic quality.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo	Ni
0.05 - 0.10	0.50 - 1.0	0.25 - 0.65	0.025 max	0.025 max	8.0 - 10.5	0.90 - 1.20	0.40 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
580 - 700	480 - 590	19 - 25	27±2°C	30 - 80

## TYPICAL APPLICATIONS

- For elevated temperature service upto 600°C.
- For boiler superheater tubing heat-exchangers, piping and pressure vessels in oil refineries and power plants.
- Forgings ASTM A 336 grade F9.
- Pipes and tubes ASTM A335 grades P9, ASTM A199 grade T9.
- A 200 grade T9, A 213 grade T9.
- Castings ASTM A 217 C12

**ASME IX QUALIFICATION :** QW-432 F. NO 4, QW-442 A-NO 5

**DIFFUSIBLE HYDROGEN IN THE WELD METAL :** 4.0ml / 100g (maximum)

**REDRYING OF ELECTRODES :** 300°C / 2hrs, 5 times max 10hrs.

**PREHEATING :** Min. 200°C before welding.

**INTERPASS TEMPERATURE :** 200°C - 250°C.

## 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