

# GRIDUCT 86G

## IDENTIFICATION

Griduct 86G, E 8016-G

## CLASSIFICATION

AWS/SFA 5.5: E8016G

## DESCRIPTION

A basic coated, low-hydrogen electrode producing a 1.0 % max nickel weld metal. The all position electrode is designed for applications demanding high yield strength and excellent fracture toughness at temperature down to minus 62°C. The welds are of radiographic quality.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Ni	Si	S	P	Mo
0.09 max	1.0 - 1.45	0.60 - 0.99	0.20 - 0.50	0.015 max	0.015 max	0.35 max

## MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
600 min	510 min	24 min	-20°C	60 min
			-40°C	60 min
			-62°C	60 min

## TYPICAL APPLICATIONS

- Off-shore fabrication, LPG tanks
- Fabrication of storage tanks, process plant and associated pipework
- ASTM A335-Grade 6 Pipe
- ASTM A350-Grade LF1 / LF2 forgings
- ASTM A352-Grade LC2 castings
- Meeting Nace specific MR-01-75 / ISO 15156 requirements.
- Diffusible hydrogen in the additional & max 4 ml / 100 g of acid metal.

**MICROSTRUCTURE** : Ferritic with a component of acicular ferrite.

**ASME IX QUALIFICATION** : QW-432 F NO 4, QW-442 A NO 10

**REDRYING TEMPERATURE** : 300°C / 1 - 2hrs

## WELDING POSITION :



## PACKING PARAMETERS

# GWELD

Size (mm)	Length (mm)	Amps AC / DC (+ / - )	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	70 - 110	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	140 - 190	5 x 4 = 20	70 x 4 = 280
5	450	180 - 250	5 x 4 = 20	45 x 4 = 180