

GRIDUCT 88C1

IDENTIFICATION

Griduct 88C1, E 8018-C1

CLASSIFICATION

AWS/SFA 5.5: E8018-C1, BS: 2493-85 2NiBH,
DIN: 8529-81 EY 46872NiBH5

APPROVALS : CE

CHARACTERISTICS:

A basic coated, low-hydrogen electrode producing a 2.5 % nickels weld metal. The all position electrode is designed for applications demanding high yield strength and excellent fracture toughness at temperature down to minus 60°C. The welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Ni	Si	S	P
0.09 max	0.50 - 1.25	2.0 - 2.75	0.20 - 0.50	0.025 max	0.025 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
560 - 650	470 - 560	19 - 26	-20°C	80 - 120
			-40°C	60 - 110
			-60°C	30 - 80

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

MICROSTRUCTURE : Ferritic with a component of acicular ferrite.

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

REDRYING TEMPERATURE : 250 - 300°C / 1 - 2hrs

RECOMMENDED CURRENT AND PACKING DATA:

Size (mm)	Length (mm)	Amps AC / DC (+ / -)	Packing / Box (kg)	Packing / Box (Pcs)
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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