GWELD
SEAL OF TRUST

Griduct 88C1

GRIDUCT 88C1

IDENTIFICATION: GRIDUCT 88C1 E8018-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 60oC. 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)
PWHT AT 6050C/5 HRS

Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Charpy V-notch impact strength	
			Temp	Joules
			- 20°C	80-120
			- 40°C	60-110
560-650	470-560	19-26	- 60°C	30-80

TYPICAL APPLICATION:
? 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

MICROSTURUCTURE: Ferritic with a component of acicular ferrite

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

REDRYING TEMPERATURE: 250-300oC / 1-2 hrs

RECOMMENDED CURRENT AND PACKING DATA:

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