

GRIDUCT 88W2

ELECTRODE FOR WELDING WEATHERING STEEL

IDENTIFICATION

Griduct 88W2, E 8018-W2

CLASSIFICATION

AWS/SFA 5.5: E 8018-W2, DIN 8529: 5043NiCuB

DESCRIPTION

A heavy coated, low-hydrogen, all-position electrode depositing weld metal having 0.5% Cr, 0.5% Ni and 0.5% Cu. The deposited weld metal exhibit improved corrosion resistance properties and therefore

recommended for welding weathering steels like Cor-Ten A, Cor-Ten B and equivalent. The weld metal also resists preferential corrosion in seawater, and has applications for welding micro-alloyed and C-Mn steels.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Cu
0.04 - 0.12	0.50 - 1.30	0.35 - 0.80	0.030 max	0.030 max	0.45 - 0.70	0.40 - 0.80	0.30 - 0.75

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 - 700	460 - 590	19 - 26	+20°C	100 - 180
			-20°C	50 - 120

TYPICAL APPLICATIONS

- For welding weathering steels type Cor-Ten A, Cor-Ten B or equivalent steels.
- ASTM A 588, Grades A, B, C, K
- DIN 1.8960, 1.8961, 1.8963
- Architectural structures, bridges, and exhaust gas fumes Chimneys, welding micro alloyed steels and C-Mn steels.

REDRYING TEMPERATURE : 300°C / 2hrs

MICROSTRUCTURE OF THE WELD METAL : Ferrite with high proportion of acicular ferrite.

WELDING POSITION :



PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC / 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 - 130	5 x 4 = 20	110 x 4 = 440
4	450	140 - 180	5 x 4 = 20	70 x 4 = 280
5	450	160 - 220	5 x 4 = 20	45 x 4 = 180