GWELD
SEAL OF TRUST

GRIDUCT 8MH4R

IDENTIFICATION
Griduct 8MH4R, E 11018M H4R

CLASSIFICATION
AWS/SFA 5.5: E11018M -H4R, IS: E76BM329Fe,
DIN: 8529 -81~ EY 6977 Mn2NiMoBH5, BS: 2493-85 2NiMOB

DESCRIPTION
An extruded heavy coated Hydrogen controlled Low-alloy, High Tensile Electrode. The electrode works in all position gives very little spatter with an easily removable slag leaving a bead of nice appearance. The deposition efficiency is approx. 110%.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.09 max	1.3 - 1.8	0.5 max	0.020 max	0.020 max	1.4 - 2.50	0.25 - 0.40	0.25 - 0.50	0.05 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
760 - 840	680 - 760	20 min	27°C	157
			-51°C	34

TYPICAL APPLICATIONS
- Penstock, earth moving equipments and heavy steel Fabrications made from high tensile steel.
- For welding USS -T1 steel, WEL -TEN 80
- Steels, SA 517 grade F and their equivalents. Specially recommended for welding ASTM AS17 Gr F Q&T steel.
- Excellent for welding fully killed fine grained steels.

WELDING PROCEDURE:
Use short arc length. Weaving of electrodes, if necessary should be done at slow speed and keeping a short arc. The electrodes should be used in perfectly dry condition. The electrodes should be dried at 400°C for 1 hour to obtain better result. Maintain interpass temperature below 120°C.

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : 4.0ml / 100g of deposited weld metal, Maximum.

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (90V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 100	2 x 6 = 12	160 x 4 = 640
3.15 / 3.20	450	90 - 130	2 x 6 = 12	110 x 4 = 440
4	450	130 - 190	2 x 6 = 12	70 x 4 = 280
5	450	190 -240	2 x 6 = 12	45 x 4 = 180