

GRIDUCT 96P2

IDENTIFICATION

Griduct 96P2, E 9016-G

CLASSIFICATION

AWS/SFA 5.5: E9016-G

DESCRIPTION

A basic type hydrogen controlled electrode specially designed for welding of high strength steels type WB-36 or equivalent. Striking and re-striking properties are good with little spatter and easy to remove slag. Deposited weld metal is tough, crack free and is of radiographic quality. The low hydrogen nature of the flux coating makes the electrode especially suited for joining crack-sensitive high strength pipes.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Ni	Mo	Cr	V
0.10 max	1.30 - 1.75	0.2 - 0.75	0.020 max	0.015 max	0.90 max	0.30 - 0.50	0.20 max	0.05 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
625 - 740	550 - 660	18 - 26	-30°C	50 - 100

TYPICAL APPLICATIONS

For welding WB-36 Steel. Welding of higher strength steel structure where post-weld heat-treatment is impracticable. Off-shore construction, pressure vessels, pipe lines, BS4360 Grade 50E, 55C, 55EF structural steel, DIN St52.3, GS-38, GS-52, etc.

WELDING PROCEDURE :

Use short arc length and stringer bead. Re-dry the electrodes at 300° C for two hours.

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

DIFFUSIBLE HYDROGEN IN THE WELD METAL : Max 5ml / 100g of weld metal.

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

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (90V) / 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 -190	5 x 4 = 20	70 x 4 = 280
5	450	190 - 250	5 x 4 = 20	45 x 4 = 180