

GRIDUCT 98M - H4R

IDENTIFICATION

Griduct 98M H4R, E 9018-M H4R

CLASSIFICATION

AWS/SFA 5.5: E 9018M-H4R DIN 8529 ESY 42761 NiBH5

DESCRIPTION

A basic coated, low hydrogen electrode depositing tough and crack free weld metal. The electrode has a very good operability in all positions except vertical down. The weld metal meets X-ray quality requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	Ni	Mo	P	Cr	V
0.09 max	0.80 - 1.25	0.20 - 0.45	0.025 max	1.40 - 1.80	0.20 - 0.35	0.025 max	0.15 max	0.05 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
620 - 740	540 - 620	24 - 30	-50°C	60 - 120

TYPICAL APPLICATIONS

- For welding high tensile steels used for pressure vessels and other applications.
- A516 grade 70 steel subjected to normalizing and stress relieving cycles
- ASTM A508 class 1, 1a, 2, 3.
- ASTM A533 Type A-D class 1 and 2, etc.

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

DIFFUSIBLE HYDROGEN CONTENT : 4 ml / 100g max

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 100	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	80 - 130	5 x 4 = 20	110 x 4 = 440
4	450	130 - 180	5 x 4 = 20	70 x 4 = 280
5	450	160 - 220	5 x 4 = 20	45 x 4 = 180