

GRIDUCT B6L

IDENTIFICATION

Griduct B6L, E 8018-B6L

CLASSIFICATION

AWS A 5.5 E8018-B6L

DIN 8575-84 ECrMo5BL20+ BS 2493-85 E5Cr MoBL

DESCRIPTION

A basic coated low hydrogen electrode depositing extra low carbon 5% Cr / 0.5% Mo weld metal. It is intended for welding creep-resisting steel of matching composition used widely in chemical and petrochemical plants because of excellent resistance to hydrogen attack and corrosion by high sulphur crude oils at service temperature upto 650°C. The weld deposit meets X-ray / Radiographic quality code requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo	Ni
0.05 max	0.5 - 1.0	0.2 - 0.6	0.025 max	0.03 max	4.0 - 6.0	0.45 - 0.65	0.40 max

MECHANICAL PROPERTIES (RANGE) PWHT (750oC/1 hr.)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
580 - 690	460 - 590	19 - 24	20°C	50 - 100

TYPICAL APPLICATIONS

- Boilers, Super heaters, Heat-exchangers, piping and pressure vessels in oil refineries.
- ASTM A387 Grade 5
- ASTM A155 Grade 5Cr
- A335 Grade P5 and P5b
- ASTM A199 Grade T5, A213 Grade T5 and T5b

MICROSTRUCTURE : In PWHT Condition : Tempered bainite

RECOMMENDED REDRYING : 300°C / 2 hrs

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

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : 4.0 ml / 100g maximum

PREHEAT TEMPERATURE : 250°C

INTERPASS TEMPERATURE : 250° - 300°C

WELDING POSITION :



1G 2F 2G 3G 4G 5G

PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC 70 OCV / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	70 - 100	5 x 4 = 20	160 x 4 = 640
3.15 / 3.20	450	80 - 140	5 x 4 = 20	110 x 4 = 440
4	450	120 - 180	5 x 4 = 20	70 x 4 = 280
5	450	150 - 220	5 x 4 = 20	45 x 4 = 180