

# 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