

GRIDUCT B8

IDENTIFICATION

Griduct B8, E 8018-B8

CLASSIFICATION

AWS/SFA 5.5: E8018- B8,
DIN 8575- ECr Mo 9B26 BS 2493 9Cr Mo BH

DESCRIPTION

A heavy basic coated type hydrogen controlled, all position iron powder Chrome-moly medium alloy electrode for elevated temperature applications. The deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo	Ni
0.05 - 0.10	0.5 - 1.0	0.25 - 0.65	0.025 max	0.025 max	8.0 - 10.0	0.9 - 1.2	0.40 max

MECHANICAL PROPERTIES (RANGE) AFTER PWHT AT 740±15oC/1 hr.

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
580 - 700	480 - 590	19 - 25	27 ± 2°C	30 - 80

TYPICAL APPLICATIONS

- For elevated temperature service upto 600° C.
- For boiler superheater tubing heat- exchangers, piping and pressure vessels in oil refineries and power plants.
- Forgings ASTM A 336 grade F9.
- Pipes and tubes ASTM A335 grades P9, ASTM A199 grade T9.
- A 200 grade T9,A 213 grade T9.
- Castings ASTM A 217 C12

ASME IX QUALIFICATION : QW-432 F.NO 4,QW-442 A-NO 5

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

REDRYING OF ELECTRODES : 300°C / 2 hrs (max 5 times, and total 10 hrs max)

PREHEAT TEMPERATURE : Min 200°C before welding

INTERPASS TEMPERATURE : 200° - 250°C

WELDING POSITION :



PACKING PARAMETERS

GWELD

Size (mm)	Length (mm)	Amps AC (70V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	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