

# GRIDUR-250

## IDENTIFICATION

Gridur 250

## CLASSIFICATION

EN 14700:EFel, DIN: 8555:E1-UM-300

## DESCRIPTION

Gridur 250 is a thick basic coated MMA Electrode for producing hardfacing deposits of medium hardness, which can be machined by chip-forming. Good weldability when positional welding, the weld deposit is crack and porosity resistant.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Fe
0.10 max	0.8 max	0.9 max	3.0 max	Remainder

## MECHANICAL PROPERTIES (RANGE)

Heat Treatment	Hardness
As welded	275 - 325 HB

## TYPICAL USES

Particularly suitable for hardfacing wear-resisting parts subject to sliding impact e.g. Slide ways, shock resistance e.g. cams and rolling impact resistance, e.g. rotors. Typical applications include rails, rail crossings, switch points, sprockets and wearing parts, such as rope pulleys, tumblers, rollers, caterpillar track rollers and links, wheel flanges, stud links and similar components.

## APPLICABLE FOR

For welding of fine grained steels and steels containing approximately 1 % Chromium, 0.5 % Nickel, 0.5% Copper, steels of dissimilar compositions having greater resistance to atmospheric corrosion. Excellent for weathering steels like Corten - A & B Steels, SAILCOR, ETC and of radiographic quality weld.

## WELDING PROCEDURE

Keep dry and avoid condensation. Re-drying recommended at 300-350°C / 2 Hrs. for 5 times max.

## PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (70V) / DC (+)	Packing / Box (kg)
2.5	350	60 - 80	5 x 4 = 20
3.15 / 3.20	450	110 - 130	5 x 4 = 20
4	450	140 - 180	5 x 4 = 20
5	450	190 - 240	5 x 4 = 20