

GRIDUR-250B

IDENTIFICATION

Gridur 250B

CLASSIFICATION

DIN 8555 E 1-UM -250

DESCRIPTION

Hydrogen controlled basic type electrode for tough easily machinable welds.

WELD METAL ANALYSIS (RANGE) %

| C | Mn | Si | S | P | Cr |
|-------------|------------|------------|-----------|-----------|-----------|
| 0.12 - 0.18 | 0.9 - 1.35 | 0.9 - 1.30 | 0.025 max | 0.025 max | 8.0 - 9.0 |

TYPICAL APPLICATIONS

- Gridur 250B electrode is used for medium hardness hard facing with high resistance to abrasion both by sliding and rolling action.
- The tough weld metal can also withstand hard blows.
- Among other applications, Gridur 250B recommended for the last 2-3 layers of the rail welding process.
- The slag is easily removable and the weld metal can be machined with cutting tools.

HARDNESS IN AS-WELDED CONDITION : 250 - 280 BHN

REDRYING OF ELECTRODES : 300°C / 2 hrs

PACKING PARAMETERS

| Size (mm) | Length (mm) | Amps AC (70V) / DC (+) | Packing / Box (kg) |
|-------------|-------------|------------------------------|-----------------------|
| 2.5 | 350 | 70 - 90 | 5 x 4 = 20 |
| 3.15 / 3.20 | 450 | 100 - 140 | 5 x 4 = 20 |
| 4 | 450 | 150 - 200 | 5 x 4 = 20 |
| 5 | 450 | 170 - 220 | 5 x 4 = 20 |