

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