GWELD
SEAL OF TRUST

GRIDUR 600R

IDENTIFICATION
Gridur 600R

DESCRIPTION
An extruded, rutile type heavy coated hard facing electrode with alloys in the coating.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Mo	Cr	V	P	S
0.5 - 0.8	0.5 - 1.5	1.0 max	0.50 max	8.0 - 9.0	0.50 max	0.03 max	0.03 max

TYPICAL APPLICATIONS
- Abrasion Proof hard facing of different parts made out of mild steel, structural steels manganese, hard steel and cast steel which are loaded by impact friction and rolling.
- Can be used on high carbon and high sulphur steels.
- Metal cutting and forming tools, punches, dies, drilling bits, shears, croppers, cane cutting Knives, bamboo chipper knives, oil expellers ,mine rails, crane wheels, mixer blades, dipper teeth, Steel mill parts, rollers , sliding surfaces, caterpillar tracks, excavator parts, rotors, crushing hammers, chunk jaws, shovel drive sprockets, mill hammers, impellers, large cog wheels, extruder screws, planner blades, drag buckets , rock drills, etc.

WELDING PROPERTIES
Arc Striking and restriking properties are excellent. Very stable arc helps weldability in down hand, vertical -up and horizontal positions. Compact slag detaches easily. Weld metal is finely rippled. Deposit is air-harden able and can only be ground.

WELDING INSTRUCTIONS
For applications on normal parent metals on special preparation is required. In case of high carbon steel buffer - layer with GEECON PURPLE is recommended. Redry electrodes at 750°C for one hour for optimum results. For use on austenitic manganese steel a buffer layer of GRILOY - 7S is recommended.

HARDNESS OF WELD METAL :
600 - 660 BHN = 55 - 56 HRC, depending on parent metal and welding conditions.

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+)	Packing / Box (kg)
2.5	350	70 - 90	5 x 4 = 20
3.15 / 3.20	450	100 - 130	5 x 4 = 20
4	450	130 - 160	5 x 4 = 20
5	450	170 - 220	5 x 4 = 20