

GRIDUR-M

IDENTIFICATION

Gridur M

DESCRIPTION

An extruded, heavy coated electrode with alloys in the coating. Arc Striking and restriking properties are very good. Arc is stable. The slag is tough ,compact and uniform, covers the deposit nicely and is easy to remove. Weld metal is very smooth and finely rippled.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
1.2 - 1.4	12.0 - 14.0	0.35 - 0.5	0.03 max	0.03 max

TYPICAL APPLICATIONS

Crusher Jaws, crusher cones, excavator teeth, mill hammers, scraper blades, manganese steel, rails and crossing ,etc. Applicable for Abrasion Proof hard facing of different parts made out of mild steel, structural steels, austenitic manganese, hard steel and cast steel which are loaded by impact friction and rolling.

WELDING INSTRUCTIONS

The deposit metal of GRIDUR-M is very tough and abrasion - Proof provided the austenitic structure is maintained. Temperature exceeding 300°C may produce brittleness. Temperature should therefore be kept as low as possible by using low welding current. Welding of short layer is recommended to avoid concentration of heat. Hammering / peening of layers is recommended.

HARDNESS OF THE WELD METAL

- **After Welding** : 180 - 200 HB
- **After Cold -working** : 450 - 500 HB

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	90 - 110	5 x 4 = 20
4	450	110 - 150	5 x 4 = 20
5	450	160 - 190	5 x 4 = 20