GWELD
SEAL OF TRUST

GRIDUR SMG

IDENTIFICATION
Gridur SMG

DESCRIPTION
A heavy coated basic type electrode predominantly siuted for tough and crack resistant joining and surfacing on parts of high Mn – steel subjected to extreme impact, compression and shock.
The weld metal consists of about 14% Mn and 3.5% Nickel. The high Mn content in the weld produces a fully austenitic deposit which is highly work-hardening.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Ni	S	P
0.80 - 1.20	13 - 14.8	0.70 - 1.10	3.0 - 4.5	0.03 max	0.04 max

TYPICAL APPLICATIONS
Dredger teeth, overlays on Manganese hardsteel, Excavator parts, bucket and teeth Mill hammers, crusher jaws, cones and beaters, Impeller bars, railway building machinery Building industry, quarries and mines for surfacing worn out parts.

WELDING INSTRUCTIONS
- Hold electrode as vertical as possible.
- Welding should be done at low temperature
- Interpass temperature should not exceed 200°C
- It is therefore recommended to weld short beads and to allow to continuous cooling during welding or to place the work piece in a cold water bath with only welding area sticking out of the water.

HARDNESS OF THE PURE WELD DEPOSIT
- **As welded** : 200 - 250 Brinell (HB)
- **After work hardening** : 450 - 550 Brinell (HB)

PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (70 OCV) / DC (+)	Packing / Box (kg)
2.5	350	70 - 90	5 x 4 = 20
3.15 / 3.20	450	110 - 140	5 x 4 = 20
4	450	150 - 180	5 x 4 = 20
5	450	180 - 220	5 x 4 = 20