

# GRICON GREEN NC

## IDENTIFICATION: GRICON GREEN NC E 7018-1

**CLASSIFICATION:** AWS/SFA 5.1: E7018-1, DIN 8529 ESY 4276MU8,  
DIN EN 499 E426B42H5 BS639-86 E5143B(24H)

### CHARACTERISTICS:

A basic coated, hydrogen controlled electrode deposits tough and crack free weld metal in butt and fillet joints. The weld metal has a very low diffusible hydrogen content and is resistant to ageing. The electrode has an extremely stable arc which enables it to be manipulated in the most difficult positions without any risk of arc extinction due to freezing. The deposited welds meet X-ray quality requirements.

**REDRYING:** 250°C / 2 hrs.

**HARDNESS OF THE WELD METAL:** 22 RC MAX

### TYPICAL APPLICATIONS

- For welding structural steels where resistance to brittle fracture is required under adverse operating conditions, Off-shore production platforms.
- Fabrication pressure vessels, nuclear containment vessels
- ASTM A106 Grades A,B,C, ASTM A516 Grades 60,70
- Bridges, Pipelines, Heavy Machinery, Tanks, Penstocks, etc.

**DIFFUSIBLE HYDROGEN IN THE WELD METAL:** 4ml Max/100 g. of weld metal

### CORROSION TEST:

Passes corrosion test as per NACE standard SSC:TM-01-77 and HIC: TM-02-84, GS-8

### HARDNESS TEST:

TM-01-03

### CURRENT CONDITIONS:

AC (70V) or DC (+)

### WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.090 max	0.90- 1.40	0.15- 0.50	0.012 max	0.015 max
Cr	Ni	Mo	V	Mn+Cr+Mo+V
0.20 max	0.30 max	0.30 max	0.08 max	1.75 max

### MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Strength	
			Temp	Joules
500-610	425-540	24-32	-46° C	40-120

### RECOMMENDED CURRENT AND PACKING DATA

SIZE (mm)	LENGTH (mm)	AMPS AC(70V)/DC(+)	PACKING/BOX (KG)
2.50	350	60-90	5 x 4 = 20 Kg
3.15	450	90-140	5 x 4 = 20 Kg
4.00	450	140-180	5 x 4 = 20 Kg
5.00	450	180-250	5 x 4 = 20 Kg

## Manufactured by: GEE LIMITED

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West)  
Thane, Maharashtra, India.  
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