

GRIDUCT B2L

IDENTIFICATION: GRIDUCT B2L E7018B2L

CLASSIFICATION: AWS A5.5: E 7018 B2L IS 1395: E 55B- B2L26Fe
BS 2493 1Cr MoLBH DIN 8575-84 ECrMo1B20+

CHARACTERISTICS:

A heavy coated ,basic type, low hydrogen all-position, except vertical down, electrode, which deposits 1.25% Cr/ 0.5%Mo weld metal. The electrode is synthetic type and is intended for welding creep resisting steels of similar composition, used in power generating plant operating at temperatures upto 5700C.The welds are of X-ray quality.

TYPICAL APPLICATIONS

- ASTM A 335 grades P11 and P12 ASTM A 155 grades ½ C,1 Cr,1 ¼ Cr, A182F11, DIN 13 CrMo44, GS-17CrMo55,BS 3604 grades 620 and 621.
- Ideal for welding Chromium-Molybdenum alloy steels (0.5Cr-0.5 Mo, 1cr-0.5 Mo, 1.25 Cr-0.5Mo), boilers, pressure vessels, headers, high pressure piping, heat exchangers and condensers, power generation, oil refineries, petrochemical industries.

WELDING PROCEDURE:

Use short arc length. Weaving of electrodes, if necessary should be done at slow speed and keeping a short arc. The electrodes should be used in perfectly dry condition

ASMEQUALIFICATION: QW-432 F.NO4, QW-442 A NO.4

RECOMMENDED REDRYING: 300°C/2 hrs, (Max. 5 times, and total 10 hrs max.)

RECOMMENDED PREHEAT & INTERPASS TEMP.: 165°C-190° C

MOISTURE IN THE FLUX COATING: 0.3% by weight, maximum

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL: Max 5 ml/100g.of weld metal

MICROSTRUCTURE: After PWHT, the microstructure consists of tempered bainite.

RECOMMENDED CURRENT AND PACKING DATA:

Size (mm)	Length (mm)	AMPS AC(70V)/DC(+)	QTY/BOX (PCS)	WEIGHT/1000 Pcs (Kg.)
2.5	350	60-80	160x4=640	18.89
3.15	450	90-130	110x4=440	41.56
4.0	450	140-190	70x4=280	67.14
5.0	450	190-250	45x4=180	104.90

Chemical Analysis of Weld Metal (Range) %

C	Mn	Si	S
0.050 max	0.5-0.9	0.2-0.6	0.015 max
P	Cr	Mo	Sn
0.012 max	1.0-1.5	0.4-0.65	0.015 Max

Mechanical Properties of Weld Metal (After PWHT at 690°C±14°C/1HR)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Value	
			Temp	Joules
530-650	425-580	19-26	-20°C	40 Min.

Manufactured by: GEE LIMITED

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

Authorised Distributor: CROSS MARKETING

Head Office: Martin Burn Business Park | Suite No 900A | Block- BP | Salt Lake | Sector - V | Kolkata - 700091 | West Bengal | India
Ph: (+91) 9163763419 | (+91) 9038320189
Email: lakhotia.ravi@gmail.com | crossmarketingkolkata@gmail.com