

GRIDUCT 4

IDENTIFICATION: GRIDUCT 4 E9018B3

CLASSIFICATION: AWS/SFA 5.5: E 9018B3, BS 2493 2CrMoBH, DIN 8575: E CrMo2B26

WELDING PROPERTIES:

Hydrogen controlled, heavy coated, basic type electrode depositing a low carbon 2.25% Cr/ 1.0Mo weld metal. It is intended for welding creep resisting steels of similar composition used in steam generation plant operating at temperature up to 600°C. The weld deposit meets x-ray/radiographic quality requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	S	P
0.05-0.12	0.4-0.9	0.025 max	0.03 max
Si	Cr	Mo	
0.2 -0.6	2.0-2.50	0.90-1.25	

ALL WELD MECHANICAL PROPERTIES PWHT 690°C/1hr

UTS (Mpa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Strength	
620-740	530-620	17-24	Temp	Joules
			27±2°C	40-90

TYPICAL APPLICATIONS

- ASTM A 199, A 200
- A 213 Grade T22, T36 & T4
- A 182 F 22
- A 387 Grade D
- A 217 WC9
- A 335 Grade P 22
- Chemical and Petrochemical industries where resistance to hydrogen attack, corrosion from sulphur bearing crude oil and stress corrosion cracking in sour atmosphere is required.

Redrying temperature for electrodes: 300°C/1 hr

Microstructure: In PWHT condition, the microstructure consists of tempered bainite

ASME IX qualification: QW 432 F-NO, QW 442 A-NO 4

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS AC (70V) DC(+)	PACKING/BOX (PCS)
2.50	350	60-90	160x4=640
3.15	450	90-140	110x4=440
4.00	450	130-180	70x4=280
5.00	450	160-220	45x4=180

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

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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)

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