

# GRICON GREEN

## IDENTIFICATION: GRICON GREEN E 7018

**APPROVED BY:** EIL at CPCL site Chennai and at BPCL site, Mumbai. Also by LRS, ABS, BV, DNV, IRS, BIS (ISI), CHIEF INSPECTOR OF BOILERS BHEL (Trichy).

**CLASSIFICATION:** AWS/SFA 5.1: E7018, IS 814: EB5426H3JX, DIN: 5144B1026

### DESCRIPTION:

Welder's friendly heavy coated basic type, hydrogen-controlled, iron powder electrode with high deposition efficiency.

### CHARACTERISTICS:

- Weld able in all positions (F.H.V.O). Welding technique including arc striking/restricting calls for practical experience for best result.
- The bead appearance is smooth and the slag is compact, thick and easily detachable. Deposition efficiency of weld metal is approx. 115%. The welds are of radiographic quality.

### TYPICAL APPLICATIONS:

- For radiographic quality welding of highly stressed crack sensitive Joints in steel structures, ship building, heavy duty boilers and pressure vessels, bridges, storage tanks, high pressure pipelines etc.
- Recommended for higher carbon & higher sulphur steels, which are susceptible to hydrogen induced cracking.

**REDRYING TEMPERATURE:** 250° C/ 2hrs

**Diffusible Hydrogen:** max 4ml/100g of deposited weld metal.

**ASME IX Qualification:** QW-432 F-NO 4, QW- 442 A-NO 1

**Moisture content in the flux coating:** 0.40% max

### RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS AC(70 OCV)/DC (+)	PACKING/BOX (PCS)	WEIGHT/1000 PCS (KG)
2.50	350	60-85	150X4=600	20.5
3.15/3.20	450	100-130	100X4=400	43.0
4.00	450	130-180	65X4=260	68.4
5.00	450	180-220	45X4=180	101.5
6.30	450	220-280	25x4=120	160.0

### WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.10 max	0.80-1.60	0.75 max	0.03 max	0.03 max
Ni	Cr	Mo	V	Mn+Ni+Cr+Mo+V
0.30 max	0.20 max	0.30 max	0.08 max	1.75 max

### MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	Elongation (%) (L=4D)	CVN Impact Strength	
			Temp	Joules
510 Min	440 min	24-30	27°C	120-200
			0°C	100-180
			-20°C	80-160
			-30°C	60-140

## 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

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