

GRIDUCT B6L

IDENTIFICATION: GRIDUCT B6L E8018B6L

CLASSIFICATION:

AWS A 5.5: E8018-B6L, DIN 8575-84 ECrMo5BL20+ BS 2493-85 E5Cr MoBL

CHARACTERISTICS:

A basic coated low hydrogen electrode depositing extra low carbon 5% Cr / 0.5% Mo weld metal. It is intended for welding creep-resisting steel of matching composition used widely in chemical and petrochemical plants because of excellent resistance to hydrogen attack and corrosion by high sulphur crude oils at service temperature upto 650°C. The weld deposit meets X-ray / Radiographic quality code requirements.

TYPICAL USES:

- Boilers, Superheaters, Heat-exchangers, piping and pressure vessels in oil refineries.
- ASTM A387 Grade 5
- ASTM A155 Grade 5Cr
- A335 Grade P5 and P5b
- ASTM A199 Grade T5, A213 Grade T5 and T5b

DIFFUSIBLE HYDREGEN CONTENT IN WELD METAL: 4.0 ml/100 g. maximum

MICROSTRUCTURE: In PWHT Condition: Tempered bainite

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

REDRYING RECOMMENDATIONS: 300oC/2 hours

PREHEAT TEMPERATURE: 250oC

INTERPASS TEMPERATURE: 250-300oC

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS AC 70 OCV/DC(+)	PACKING/BOX (PCS)
2.50	350	70-100	160X4=640
3.15	450	80-140	110X4=440
4.00	450	120-180	70X4=280
5.00	450	150-220	45X4=180

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S
0.050 max	0.5-1.0	0.20-0.60	0.025 max
P	Cr	Mo	Ni
0.03 max	4.0-6.0	0.45-0.65	0.40 max

MECHANICAL PROPERTIES (RANGE) PWHT (750°C/1 hour)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact	
			Temp.	Joules
580-690	460-590	19-24	20°C	50-100

Manufactured by: GEE LIMITED

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