

GRIDUCT B8L

IDENTIFICATION: GRIDUCT B8L E8018 B8L

CLASSIFICATION:

AWS/SFA 5.5: E8018 B8L, BS 2493 9CrMoBLH, DIN 8575 ECrMo9LB26

CHARACTERISTICS:

A medium-heavy coated, basic type, low hydrogen electrode depositing extra low carbon 9.0% Cr / 1.0 Mo weld metal. It is intended for welding in refineries and power plants. The weld metal meets x-ray/ radiographic quality code requirements.

TYPICAL APPLICATIONS

- For boilers, super heater tubes, heat exchangers, piping and pressure vessels in oil refineries and power plants.
- ASTM A 336 Grade F9
- ASTM A 217 C12 , BS 1504 Grade 629 and BS 3100 Grades 629/1470
- ASTM A 335 Grade P9
- A 199 Grade T9, A200 Grade T9, A213 Grade T9

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

ASME IX qualification: QW-432 F No 4, QW-442 A No 5

REDRYING TEMPERATURE: 300oC / 2 hrs.

Weld-Metal Composition (%)

C	Mn	Si	S
0.05 max	0.5-1.0	0.2-0.6	0.025 max
P	Cr	Mo	Ni
0.025 max	8.0-10.5	0.85-1.20	0.40 max

All-Weld Mech. Properties (PWHT 726-754°C/1hr)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)
590-720	520-620	19-24

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (MM)	LENGTH (MM)	AMPS AC (70V) DC(+)	PACKING/BOX (PCS)	WEIGHT/1000PCS (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

Manufactured by: GEE LIMITED

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