

GRICON GREEN (SPL)

IDENTIFICATION: GRICON GREEN (SPL) E7018-1

CLASSIFICATION:

AWS/SFA 5.1: E7018-1, IS 814: EB5626H3 JX,
BS: E5155B (11026H) DIN: 5155B1029

APPROVALS: LRS, IBR, HPCL, ABS

CHARACTERISTICS:

A heavy coated basic type, hydrogen-controlled, iron powder electrode with high deposition efficiency. The electrode deposits weld metal, which is of radiographic quality and meets impact requirements.

The weld deposit is tough, ductile and is highly resistant to hot or cold cracking even when subjected to high stresses, dynamic loading etc.

TYPICAL APPLICATIONS

- For the welding of structural steel where resistance to brittle fracture is required under adverse operating conditions such as those found in off-shore production platforms.
- Used for production of pressure vessels, bridges, pipelines recommended for higher carbon & higher Sulphur steels, which are susceptible to hydrogen induced cracking.
- For welding SAILMA 350HI steel.

REDRYING TEMPERATURE: 250 C/ 2hrs

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

DIFFUSIBLE HYDROGEN: Max 5.0ml/100g of weld metal in the weld metal

RECOMMENDED CURRENT AND PACKING DATA

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (+)	PACKING/BOX (PCS)
2.50	350	65-85	150×4=600
3.15/3.20	450	110-140	100×4=400
4.00	450	140-180	65×4=260
5.00	450	180-240	45×4=180
6.30	450	220-280	25×4=120

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.10 max	1.2-1.6	0.45 max	0.025 max	0.025 max
Cr	Ni	Mo	V	Combined limit for Mn+Cr+Mo+Ni+V
0.20 max	0.30 max	0.30 max	0.08 max	1.75 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) L=4D)	CVN Impact Value	
			Temp	Joules
500-600	440-540	24-30	-46°C	50-150
			-50°C	50-120

Manufactured by: GEE LIMITED

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