

GRICON GREEN (SPL) NC

IDENTIFICATION : GRICON GREEN (SPL) NC E7018

CLASSIFICATION:

AWS/SFA 5.1-2004: E7018,
DIN 8529 ESy 4276MU8, DIN EN 499 E426B42H5, BS639-86: E5143B(24H)

CHARACTERISTICS:

A basic coated, hydrogen controlled electrode deposits tough and crack free weld metal in butt and fillet joints. The weld metal has a very low diffusible hydrogen content and is resistant to ageing. The electrode has an extremely stable arc which enables it to be manipulated in the most difficult positions without any risk of arc extinction due to freezing. The deposited welds meet X-ray quality requirements.

TYPICAL APPLICATIONS

For welding of Nace grade Steel such as A 516 Gr.70, A106GrB, etc.

- Fabrication pressure vessels, Nuclear containment vessels.
- ASTM A106 Grades A,B,C
- ASTM A516 Grades 60,70
- Bridges, Pipelines, Heavy Machinery, Tanks, Penstocks, etc.

HARDNESS OF THE WELD METAL: 22 RC MAX

DIFFUSIBLE HYDROGEN IN THE WELD METAL: 4ml Max/100 g. of weld metal

CORROSION TEST: Passes corrosion test as per NACE standard TM-01-77 AND TM-02-84, GS-8

REDRYING: 300oC / 2 hrs.

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS AC(70V)/DC(+)	PACKING/BOX (PCS)	WEIGHT/1000 PCS (KG)
2.50	350	60-90	150X4=600	21.0
3.20	450	90-140	100X4=400	45.0
4.00	450	140-180	60X4=240	66.0
5.00	450	180-250	40X4=160	95.0

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.090 max	0.90-1.40	0.15-0.50	0.012 max	0.015 max
Cr	Ni	Mo	V	Mn+Cr+Mo+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	
500-610	425-540	24-32	Temp	Joules
			-30°C	40-120

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

Head Office: Martin Burn Business Park | Suite No 900A | Block- BP | Salt Lake | Sector - V | Kolkata - 700091 | West Bengal | India
Ph: (+91) 9163763419 | (+91) 9038320189
Email: lakhotia.ravi@gmail.com | crossmarketingkolkata@gmail.com

<https://crossmarketing.co.in>