

GRIDUCT B8L

IDENTIFICATION

Griduct B8L, E 8018-B8L

CLASSIFICATION

AWS/SFA 5.5 E8018 B8L, BS 2493 9CrMoBLH,
DIN8575 ECrMo9LB26

DESCRIPTION

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

WELD METAL ANALYSIS (RANGE) %

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

MECHANICAL PROPERTIES (RANGE) PWHT (726-7540C/1hr)

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

TYPICAL APPLICATIONS

- For boiler superheater tubing 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 6291470
- 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 OF TEMPERATURE : 300° - 350°C / 2 hrs

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC (70V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	5 x 4 = 20	160 x 4 = 640
3.15/3.20	450	90 - 130	5 x 4 = 20	110 x 4 = 440
4	450	140 - 190	5 x 4 = 20	70 x 4 = 280
5	450	190 - 250	5 x 4 = 20	45 x 4 = 180

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